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PATENT

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of:

Confirmation Number: 1981

Osamu NAGAI et al.

Attorney Docket: P67506US0

Serial No. 10/030,076

Group Art Unit: 1752

Filed: January 10, 2002

Examiner: Hoa Van LE

For: GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME

PETITION TO THE DIRECTOR UNDER 37 C.F.R. §§ 1.181 – 182

Mail Stop Petition
Commissioner for Patents
P.O. Box 1450
Alexandria, VA 22313-1450

Sir:

For the above referenced application, Applicant respectfully petitions to Director for:

- (1) entry of Claims 23 – 24 as originally filed on January 10, 2002;
- (2) issuance of a new office action by Examiner to examine all pending claims, including Claims 23 – 24; and
- (3) refund of the three-month extension fee of USD 950.00 paid for responding an incomplete office action, in which Claims 23 – 24 were not examined, in order to keep the above reference application pending.

Introduction:

On January 10, 2002, Applicant filed a patent application with the United States Patent and Trademark Office (“USPTO”) under 35 USC § 371 as the national stage entry

of a PCT application. The application includes 24 Claims, in which Claims 23 – 24 were added during international stage. In a non-final Office Action dated February 20, 2004 from the USPTO, Examiner indicated that “Claims 1 – 22 are pending.” Claims 23 and 24 were not mentioned in any part of the Office Action. On June 10, 2004, Applicant, through undersigned attorney and associate, contacted the Examiner, who admitted that Claims 23 – 24 were missing and agreed the issuance of a new office action to act on Claims 23 – 24 once the missing claims were submitted through facsimile. On June 10, 2004, Applicant, through the undersigned attorney, immediately sent the missing claims and supporting documents through facsimile, which PTO returned confirmation of receipt by facsimile. However, no new office action has been issued. On July 21, 2004, Applicant, through the undersigned attorney, contacted Examiner regarding the promised new office action. Examiner refused to issue new office action by citing that Claims 23 – 24 were not received, which is contrary to the fact and proof of records. In addition, Examiner refused to accept resending the missing claims and recommended Applicant responding to the incomplete office action and adding Claims 23 – 24 as newly added claims with three-month extension fee. Since Applicant properly followed the USPTO rules and regulations in filing the original application including Claims 23 – 24, and resent the missing pages in reliance on the issuance of a new office action as promised by Examiner, it is unreasonable and unjustified to file a response to incomplete office action and add Claims 23 – 24 as newly added claims with three-month extension fee. Applicant hereby petitions to Director for the relief listed above under 37 CFR 1.181-182. The petition fee under 37 CFR § 1.17(h) in the amount of USD 130.00 is submitted herewith. The action complained of by Applicant occurred on July 21, 2004. Therefore, the present petition is filed timely within 2 months of the act complained of and satisfy the requirement under 37 CFR § 1.181(f).

Statement of Facts:

Application Filed on January 10, 2002 Includes Claims 23 – 24

Applicant, through undersigned attorney, filed a patent application (“Application”) with the USPTO under 35 USC § 371 as the national stage entry of a PCT application with application number of PCT/JP00/03853 on January 10, 2002. The Application includes 78 pages of specification, 24 claims, Abstract, and Article 19 Amendment letter in both English and Japanese, as well as preliminary amendment, international search report, PCT/IB/304/346 form(s), first page of publication, international preliminary search report, Declaration and Power of Attorney, assignment documents and cover sheet. (See Exhibit I: copy of submitted Application)

Applicant, through undersigned attorney, paid proper filing fees, including filing fee for total 24 claims and 8 independent claims, including independent Claims 23 and 24. (See Exhibit II: copies of the transmittal letter and check) In addition, Applicant, through undersigned attorney, properly pointed out that “Amendments to the claims of International Application under PCT Article 19 are transmitted herewith and have been transmitted by the International Bureau.” Furthermore, a translation of the amendments to the claims under PCT Article 19 was provided. (See Exhibit III: copies of transmittal letter (Item No. 7a., 7b. and 8) and Article 19 Amendment letters)

The Application, together with two self-addressed postcards properly itemized the above filed contents of the Application, was hand carried to the PCT window, Crystal Plaza II, 8th Floor, Arlington, VA 22202 on January 10, 2002. The postcards were stamped with the filing date and an early serial number 10/030,076. (See Exhibit IV: copies of two stamped postcards) It is respectfully submitted that these postcards constitute proof that the Application with all the identified contents thereon were received by USPTO on January 10, 2002.

First Non-final Office Action Did Not Include Action on Claims 23 – 24

On February 26, 2004, Applicant, through under signed attorney, received a non-final Office Action dated February 20, 2004 from the USPTO. In the Office Action, Examiner indicated that “Claims 1 – 22 are pending.” Claims 23 and 24 were not

mentioned in any part of the Office Action. (See Exhibit V: Copy of Office Action dated February 20, 2004)

Applicant Submitted The Missing Claims 23 – 24 and Requested for New Office Action

On June 10, 2004, Mr. Jiwen Chen, an associate attorney working with the undersigned attorney, contacted Examiner via telephone regarding the missing Claims 23 – 24. Examiner agreed that Applicant could resend the pages containing Claims 23 – 24, and other supporting documents, and he would issue a new Office Action with the statutory period of reply starting from the mailing date of the new Office Action. After the conversation, Applicant, through the undersigned attorney, immediately submitted the copies of the specification with pages including missing Claims 23 – 24, Abstract (pages 75 – 78), transmittal letter, check, postcard, Article 19 amendment letter, 16 pages in total, to Examiner via facsimile through the designated fax number (703-872-9306) on June 10, 2004. (See Exhibit VI: Copy of facsimile on June 10, 2004 resending the missing Claims 23 – 24 and supporting documents) An automatically generated return receipt confirmation of the facsimile transmission by the USPTO was received on the same day of June 10, 2004. The receipt confirms that all 16 pages were transmitted to and received by the USPTO. (See Exhibit VII: Copy of Return Receipt Confirmation of the Facsimile Transmission)

Examiner Failed to Issue A New Office Action on Claims 23 – 24

Applicant, however, has never received the promised new Office Action including the action on the Claims 23 – 24.

Examiner Refused Applicant's Further Request for Resubmitting Missing Claims 23 -- 24 and Recommended Responding to The Incomplete Action and Adding Missing Claims at Applicant's Expense

On July 21, 2004, Applicant, through undersigned attorney, contacted Examiner by telephone and made inquiry regarding the expected new office action on missing

claims. Examiner indicated that he did not have the page with Claims 23 – 24. The undersigned attorney indicated that the page with Claims 23 – 24 could be re-transmitted to the USPTO. However, Examiner refused such request. Instead, Examiner recommended Applicant filing a response to the incomplete Office Action and adding Claims 23 – 24 as new claims with three-month extension fee.

Points to be Reviewed:

Whether the failure by the USPTO to enter the originally filed Claims 23 – 24 justifies the entry of Claims 23 – 24?

Whether it is justified for the USPTO to issue a new office action that examines all pending claims including Claims 23 – 24?

Whether it is justified by the USPTO to waive and refund the paid three-month extension fee in responding the incomplete office action to keep the present application pending?

Action Requested:

Applicant respectfully petitions for:

- (1) entry of Claims 23 – 24 as originally filed on January 10, 2002;
- (2) issuance of a new office action by Examiner to exam all pending claims, including Claims 23 – 24; and
- (3) refund the three-month extension fee of USD 950.00 paid for responding an incomplete office action, excluding Claims 23 – 24, in order to keep the above reference application pending.

Argument:

Examiner's Refusal to Entry of Claims 23 – 24 Is Unreasonable and Unjustified

As the above Statement of Facts clearly shows, Applicant submitted twice to the USPTO the application papers including Claims 23 – 24: the first time as a part of original application filed on January 10, 2002, and the second time as re-submitted documents on June 10, 2004. Applicant followed all the applicable USPTO rules and regulations in submitting Claims 23 – 24. The stamped postcard and facsimile receipt are proof that these papers were received by the USPTO. According to MPEP § 503, a postcard receipt which itemizes and properly identifies the items which are being filed serves as prima facie evidence of receipt in the USPTO of all items listed thereon on the date stamped thereon by the USPTO. The stamped postcard was properly itemized to identify the pages of specification, number of claims, the Article 19 amendment, etc. The returned receipt for facsimile transmission of 16 pages including Claims 23 – 24 and supporting documents was also properly itemized.

In addition, there is no evidence to the contrary to indicate that the USPTO did not receive and possess Claims 23 – 24.

At first, MPEP § 503 requires that “[T]he person receiving the item(s) in the USPTO will check the listing on the postcard against the item(s) being filed to be sure that they are properly identified and that all the items listed on the postcard are presently being submitted to the USPTO. If any of the items listed on the postcard are not being submitted to the USPTO, those items will be crossed off and the postcard initialed by the person receiving the items.” None of the properly identified items on the postcard submitted together with the present application was crossed off.

Secondly, MPEP § 702 requires that “[W]hen a new application is assigned in the Technology Center, the examiner should review the contents of the application to determine if the application meets the requirements of 35 U.S.C. 111(a).” In addition, “[T]he examiner should be careful to see that the application meets all the requests set forth in MPEP Chapter 600 both as to format matters and as to the completeness and clarity of the disclosure. If all of the requisites are not met, applicant may be called upon for necessary amendments.” The Application as submitted clearly included Claims 23 – 24 on page 76. The transmittal letter clearly stated that Article 19 amendment was made in international stage. The copies of Article 19 amendment letter in both English and Japanese languages were also provided. The claims fees obviously included Claims 23-24, otherwise the total claims will not be 24 and independent claims will not be 8. If there is any doubt regarding the presence of the above mentioned documents, the USPTO, through Examiner, should have “called upon” applicant for necessary amendment or inquiry. The fact of the matter is that Applicant never received any notice indicating that Claims 23 – 24 were not part of the Application until the incomplete office action was received.

Therefore, all the evidence proves that the USPTO received and had possession of Claims 23 – 24. Claims 23 – 24, which were properly submitted and paid for, should be entered. Even if the USPTO did not received the Claims 23 – 24, which were twice submitted, it should give Applicant the opportunity to re-submit Claims 23 – 24 for consideration in a new Office Action. Examiner’s refusal of entry of Claims 23 – 24 is arbitrary, capricious and an abuse of discretion. Accordingly, Claims 23 – 24 should be entered.

A New Office Action Including Action on All Pending Claims, Including Claims 23 – 24 Should Be Issued

Examiner’s refusal to further submission of Claims 23 – 24, and refusal to act on Claims 23 – 24 violate the USPTO rules and regulations dictating the patent examination procedures. More specifically, 37 CFR 1.104 (b) requires that the examiner’s action shall

be complete as to all matters. Applicant is entitled to have all the pending claims examined. Therefore, a new office action including action on Claims 23 – 24 should be issued.

The Paid Three-month Extension Fee in Responding The Incomplete Office Action To Keep The Present Application Pending Should Be Refunded

Because the period for responding pending office action will not stay because of the present petition, Applicant has to file a response to the incomplete office action and pay three-month extension fee. As the above fact and argument show, it is arbitrary, capricious and an abuse of discretion to deny to the entry of Claims 23 – 24 and refuse to issue a new complete office action examining Claims 23 – 24. Because Examiner's unreasonable and unjustified action, Applicant has to respond the incomplete office action and pay three-month extension fee. Applicant hereby requests the USPTO to waive and refund the paid three-month extension fee

Conclusions:

Applicant twice properly submitted Claims 23 – 24 for examination. Examiner unreasonably and unjustifiably denied the requests for entry of Claims 23 – 24 and issuance of a new office action examining Claims 23 – 24. Applicant respectfully petitions to Director for:

(1) entry of Claims 23 – 24 as originally filed on January 10, 2002;

(2) issuance of a new office action by Examiner to exam all pending claims, including Claims 23 – 24; and

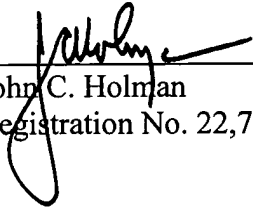
(3) refund of the three-month extension fee of USD 950.00 paid for responding an incomplete office action, in which Claims 23 – 24 were not examined, in order to keep the above reference application pending.

Your prompt grant of the present petition is respectfully requested.

Respectfully submitted,

JACOBSON HOLMAN PLLC

Date: July 27, 2004
(202) 638-6666
400 Seventh Street, N.W.
Washington, D.C. 20004
Atty. Dkt. No.: P67506US0

By 
John C. Holman
Registration No. 22,769

Enclosures:

Exhibit I: copy of submitted Application

Exhibit II: copies of the transmittal letter and check

Exhibit III: copies of transmittal letter (Item No. 7a., 7b. and 8) and Article 19
Amendment letters

Exhibit IV: copies of two stamped postcards

Exhibit V: copy of Office Action dated February 20, 2004

Exhibit VI: copy of facsimile on June 10, 2004 resending the missing Claims 23 –
24 and supporting documents

Exhibit VII: copy of return receipt confirmation of the facsimile transmission

Credit Card Payment Form (PTO-2038) authorizing payment of petition fee in the
amount of \$130.00

TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED / ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		ATTORNEY'S DOCKET NUMBER P67506US0
		US APPLICATION NO. (If known, see 37 CFR 1.5)
INTERNATIONAL APPLICATION NO. PCT/JP00/03853	INTERNATIONAL FILING DATE 14 June 2000	PRIORITY DATE CLAIMED 13 July 1999
TITLE OF INVENTION GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME		
APPLICANT(S) FOR DO/EO/US Osamu NAGAI, Shigeo WAKAMATSU and Yuichi KUROKI		

Applicant herein submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information.

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for Internatl. Preliminary Examination was made by the 19th month from earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☒ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☒ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
10. ☐ A translation of the annexes to the Internatl. Preliminary Examination report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern other document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☒ An assignment document for recording. A separate cover sheet compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A **FIRST** preliminary amendment.
☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
14. ☐ A substitute specification.
15. ☐ A change of power of attorney and/or address letter.
16. ☒ Other items or information:

International Search Report – JPO
PCT/IB/304 Form
PCT/IB/346 Form
First Page of Publication
International Preliminary Examination Report

US APPLICATION NO. (If known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO. PCT/JP00/03853		ATTORNEY'S DOCKET NUMBER P67506US0	
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<p>17. <input checked="" type="checkbox"/> The following fees are submitted:</p> <p>Basic National Fee (37 CFR 1.492(a)(1)-(5)):</p> <p>Internatl. prelim. examination fee paid to USPTO (37 CFR 1.492 (a) (1)) .. \$710.00</p> <p>No international preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (2)) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) .. \$740.00</p> <p>Neither international preliminary examination fee (37 CFR 1.492 (a) (3)) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO) \$1040.00</p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (4)) and all claims satisfied provisions of PCT Article 33(2)-(4) \$100.00</p> <p>Search Report prepared by the EPO or JPO (37 CFR 1.492 (a) (5)) \$890.00</p> <p style="text-align: center;">ENTER APPROPRIATE BASIC FEE AMOUNT =</p>				CALCULATIONS		PTO USE ONLY	
<p>Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).</p>				\$			

Claims	Number Filed	Number Extra	Rate		
Total Claims	24 - 20 =	-4-	x \$18.00	\$	72.00
Independent Claims	8 - 3 =	-5-	x \$84.00	\$	420.00
Multiple Dependent Claim(s) (if applicable)			+ \$280.00	\$	
TOTAL OF ABOVE CALCULATIONS =				\$	1382.00
Reduction by 1/2 for filing by small entity, if applicable. Verified Small Entity statement must also be filed. (Note 37 CFR 1.9, 1.27, 1.28).				\$	
SUBTOTAL =				\$	1382.00
Processing fee of \$130 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f))				\$	
TOTAL NATIONAL FEE =				\$	1382.00
Fee of \$40.00 for recording the enclosed assignment (37 CFR 1.21(h)). Assignment must be accompanied by appropriate cover sheet (37 CFR 3.28, 3.31).				\$	
TOTAL FEES ENCLOSED =				\$	1422.00
				Amt. to be refunded:	\$
				Amt. charged:	\$

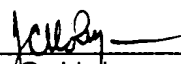
a. ☒ A check in the amount of \$ 1422.00 to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. 06-1358 in the amount of \$ _____ to cover the above fees.
A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge my account any additional fees set forth in §1.492 during the pendency of this application, or credit any overpayment to Deposit Account No. 06-1358. A duplicate copy of this sheet is enclosed.

SEND ALL CORRESPONDENCE TO:

JACOBSON HOLMAN PLLC
400 7th Street, N.W., Suite 600
Washington, DC 20004
202-638-6666
CUSTOMER NUMBER: 00136

By 
John C. Holman
Reg. No. 22,769

JPH&S 3/95

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicants: Osamu NAGAI et al
Serial No.: New
Filing Date: January 10, 2002
For: GASKET FOR FUEL BATTERY AND METHOD OF
FORMING THE SAME

PRELIMINARY AMENDMENT

Assistant Commissioner of Patents
Washington, D.C. 20231

Sir:

Prior to initial examination, please amend the above-identified application as follows:

IN THE SPECIFICATION

Please insert the following sentence on line 1, immediately following the title:

--This is a nationalization of PCT/JP00/03853, filed June 14, 2000, and published in Japanese.--

IN THE CLAIMS

Please amend claim 19 as follows:

19. (amended) A method of forming a gasket for a fuel battery as claimed in claim 1, characterized in that a gap is provided between upper and lower molds before injecting so as to evacuate, and thereafter the molds are clamped so as to injection mold the gasket lip.

REMARKS

The foregoing Preliminary Amendment is requested in order to delete the multiple dependent claims and avoid paying the multiple dependent claims fee.

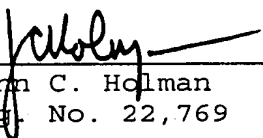
Attached hereto is a marked-up version of the changes made to the specification and claims by the current amendment. The attached page is captioned "VERSION WITH MARKINGS TO SHOW CHANGES MADE."

Early action on the merits is respectfully requested.

Respectfully submitted,

JACOBSON HOLMAN PLLC

By


John C. Holman
Reg. No. 22,769

400 Seventh Street, N.W.
Washington, D.C. 20004-2201
(202) 638-6666

Atty. Docket: P67506US0
Date: January 10, 2002
JCH:jrc

VERSION WITH MARKINGS TO SHOW CHANGES MADE

IN THE CLAIMS

19: (amended) A method of forming a gasket for a fuel battery as claimed in claim 1 ~~any one of claims 1 to 18~~, characterized in that a gap is provided between upper and lower molds before injecting so as to evacuate, and thereafter the molds are clamped so as to injection mold the gasket lip.

30 October, 2000

World Intellectual Property Organization
PCT Division
34 Chemin des Colombettes
1211 Geneva 20
Switzerland

Amendment of the claims under Article 19(1) (Rule 46)

International Application No.: PCT/JP00/03853

International Filing Date: 14 June, 2000

Applicant: NOK CORPORATION et al.

address: 12-15, Shibadaimon 1-chome,

Minato-ku, Tokyo 105-8585 Japan

telephone number(national):0466-35-4608 (international):81-466-35-4608

Agent: NOMOTO Yoichi

address: Terao-Building 7th Floor,

8-4, Nishi-shinbashi 2-chome

Minato-ku, Tokyo 105-0003 Japan

telephone number(national): 03-3506-7879 (international):813-3506-7879

Applicant's or Agent's File reference: PCT-16069

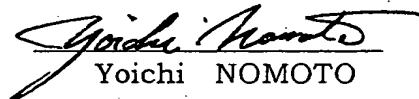
Dear sir

The Applicant, who received the International Search Report relating to the above identified International Application transmitted on 14 June 2000, hereby files amendment under Article 19(1) as in the attached sheets.

Claims 23 and 24 are added by this amendment.

The Applicant also files as attached herewith a brief statement explaining the amendment.

Very truly yours,


Yoichi NOMOTO

Attachment:

- | | |
|-----------------------------------|----------|
| (1) Amendment under Article 19(1) | 4 sheets |
| (2) Brief Statement | 1 sheet |

請求の範囲

1. 平面プレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。
2. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
平面プレートが、集電極、イオン交換膜または膜固定反応電極であることを特徴とする燃料電池用ガスケット。
3. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物が、硬さ（J I S A）60以下であることを特徴する燃料電池用ガスケット。
4. 請求の範囲第3項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物の硬さ（J I S A）が好ましくは5～50、より好ましくは10～40であることを特徴する燃料電池用ガスケット。
5. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴムの粘度（Pa・s（25℃））が30～10,000、好ましくは300～2,000であることを特徴とする燃料電池用ガスケット。
6. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物よりなるガスケットリップの断面形状が台形または山形であることを特徴とする燃料電池用ガスケット。
7. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物よりなるガスケットリップの断面形状が、断面台形の部分または断面山形の部分を備えていることを特徴とする燃料電池用ガスケット。
8. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
ガスケットリップのシール部は断面円弧状であることを特徴とする燃料電池用ガスケット。
9. 請求の範囲第8項に記載した燃料電池用ガスケットにおいて、
シール部は高さが略0.2～1.5mmであることを特徴とする燃料電池用ガ

スケット。

10. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップのシール部は断面山形、凸形ないし三角形状であることを特徴とする燃料電池用ガスケット。

11. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部は高さが略0.3～1.5mmであることを特徴とする燃料電池用ガスケット。

12. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部の先端部は断面円弧状であることを特徴とする燃料電池用ガスケット。

13. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップの断面形状が互いに異なるように形成され、一方の前記ガスケットリップに、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

14. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

15. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、イオン交換膜を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記イオン交換膜に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

16. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を覆うよ

うにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

17. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布し、その領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

18. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布せずにその領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

19. 請求の範囲第1項ないし第18項の何れかに記載した燃料電池用ガスケットの成形方法において、

射出前に上下金型の間に隙間を設けて真空引きし、その後、型締めしてガスケットリップを射出成形することを特徴とする燃料電池用ガスケットの成形方法。

20. 請求の範囲第19項に記載した燃料電池用ガスケットの成形方法において、

平面プレートの両面または前記両面に施された溝部の底面に開口する貫通穴を設け、前記貫通穴を介して前記両面または両溝部に同時にガスケットリップを一体成形することを特徴とする燃料電池用ガスケットの成形方法。

21. 基板の両面に互いに対応する一対の溝部を設け、前記一対の溝部を連通するように前記基板に連通孔を設け、前記一対の溝部および連通孔にエラストマーを充填するとともにこのエラストマーに凸状のシールリップを設け、前記連通孔を前記溝部の幅方向の一方に偏った位置に配置するとともに前記凸状のシールリップを反対側に偏った位置に配置したことを特徴とする燃料電池用ガスケット。

22. 基板の両面にエラストマーからなるシールリップを一体に備えるガスケットの製造において、

前記基板に、その両面に衝合される金型との間に形成されるシールリップ成形用キャビティの間を連通する連通孔を開設し、

前記連通孔は前記両シールリップ成形用キャビティの一方へ開口したゲートと対応する位置にあつてこのゲートよりも大径に形成され、

前記ゲートから供給される成形材料を前記連通孔を介して前記両シールリップ成形用キャビティへ充填することを特徴とするガasketの成形方法。

23. (追加) カーボンプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガasketリップを一体成形したことを特徴とする燃料電池用ガasket。

24. (追加) グラファイトプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガasketリップを一体成形したことを特徴とする燃料電池用ガasket。

条約第 19 条（1）に基づく説明書

新たに追加する請求の範囲第 23 項は、カーボンプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、本件国際調査報告で引用された何れの引例にも記載されていないものである。

また、同じく新たに追加する請求の範囲第 24 項は、グラファイトプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、やはり本件国際調査報告で引用された何れの引例にも記載されていないものである。

A. 発明の属する分野の分類 (国際特許分類 (IPC))
Int.Cl⁷ H01M8/02, F16J15/14

B. 調査を行った分野

調査を行った最小限資料 (国際特許分類 (IPC))
Int.Cl⁷ H01M8/00-8/24, F16J15/14

最小限資料以外の資料で調査を行った分野に含まれるもの

日本国実用新案公報 1922-1996年
日本国公開実用新案公報 1971-2000年
日本国登録実用新案公報 1994-2000年
日本国実用新案登録公報 1996-2000年

国際調査で使用了電子データベース (データベースの名称、調査に使用した用語)
JOIS (ネリョウゲンチ, ガスケツ, フウシ)

C. 関連すると認められる文献

引用文献の カテゴリー*	引用文献名 及び一部の箇所が関連するときは、その関連する箇所の表示	関連する 請求の範囲の番号
Y	日本国実用新案登録出願56-13038号 (日本国実用新案登録出願公開57-125746号) の願書に添付した明細書及び図面の内容を撮影したマイクロフィルム (株式会社スリーボンド) 5.8月.1982(05.08.82), 全文 (ファミリーなし)	1-12, 14, 15, 19, 20
Y	JP08-37012A (富士電機株式会社) 6.2月.1996 (06.02.96), 図1の72, 613 (ファミリーなし)	1-12, 14, 15
Y	JP58-155670A (株式会社日立製作所) 16.9月.1983 (16.09.83), 図3 (ファミリーなし)	1-12, 14, 15

☒ C欄の続きにも文献が列挙されている。

☐ パテントファミリーに関する別紙を参照。

* 引用文献のカテゴリー

「A」 特に関連のある文献ではなく、一般的技術水準を示すもの
「E」 国際出願日前の出願または特許であるが、国際出願日以後に公表されたもの
「L」 優先権主張に疑義を提起する文献又は他の文献の発行日若しくは他の特別な理由を確立するために引用する文献 (理由を付す)
「O」 口頭による開示、使用、展示等に言及する文献
「P」 国際出願日前で、かつ優先権の主張の基礎となる出願

の日の後に公表された文献

「T」 国際出願日又は優先日後に公表された文献であって出願と矛盾するものではなく、発明の原理又は理論の理解のために引用するもの
「X」 特に関連のある文献であって、当該文献のみで発明の新規性又は進歩性がないと考えられるもの
「Y」 特に関連のある文献であって、当該文献と他の1以上の文献との、当業者にとって自明である組合せによって進歩性がないと考えられるもの
「&」 同一パテントファミリー文献

国際調査を完了した日
12.09.00

国際調査報告の発送日
19.09.00

国際調査機関の名称及びあて先
日本国特許庁 (ISA/JP)
郵便番号100-8915
東京都千代田区霞が関三丁目4番3号

特許庁審査官 (権限のある職員)
高木 康晴



4X 9275

電話番号 03-3581-1101 内線 3477

C (続き) . 関連すると認められる文献		
引用文献の カテゴリー*	引用文献名 及び一部の箇所が関連するときは、その関連する箇所の表示	関連する 請求の範囲の番号
Y	EP671575A2 (TOYOTA JIDOSHA KABUSHIKI KAISHA) 13.09.1995 (13.09.95) F I G 1 4 & JP07-137085A	19, 20
A	JP07-65847A (関西電力株式会社) 10.3月.1995 (10.03.95), 第5頁左 欄第50行 (ファミリーなし)	1-22
P X	JP2000-77084A (三菱樹脂株式会社) 14.3月.2000 (14.03.00), 全文 (ファミリーなし)	1-5

PATENT COOPERATION TREATY

11/28

PCT

From the INTERNATIONAL BUREAU

NOTIFICATION CONCERNING
SUBMISSION OR TRANSMITTAL
OF PRIORITY DOCUMENT

(PCT Administrative Instructions, Section 411)

To:

NOMOTO, Yoichi
Terao-Building
7th floor
8-4, Nishi-Shinbashi 2-chome
Minato-ku
Tokyo 105-0003
JAPON

Date of mailing (day/month/year) 16 November 2000 (16.11.00)	
Applicant's or agent's file reference PCT-16069	IMPORTANT NOTIFICATION
International application No. PCT/JP00/03853	International filing date (day/month/year) 14 June 2000 (14.06.00)
International publication date (day/month/year) Not yet published	Priority date (day/month/year) 13 July 1999 (13.07.99)
Applicant NOK CORPORATION et al	

1. The applicant is hereby notified of the date of receipt (except where the letters "NR" appear in the right-hand column) by the International Bureau of the priority document(s) relating to the earlier application(s) indicated below. Unless otherwise indicated by an asterisk appearing next to a date of receipt, or by the letters "NR", in the right-hand column, the priority document concerned was submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b).
2. This updates and replaces any previously issued notification concerning submission or transmittal of priority documents.
3. An asterisk(*) appearing next to a date of receipt, in the right-hand column, denotes a priority document submitted or transmitted to the International Bureau but not in compliance with Rule 17.1(a) or (b). In such a case, the attention of the applicant is directed to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.
4. The letters "NR" appearing in the right-hand column denote a priority document which was not received by the International Bureau or which the applicant did not request the receiving Office to prepare and transmit to the International Bureau, as provided by Rule 17.1(a) or (b), respectively. In such a case, the attention of the applicant is directed to Rule 17.1(c) which provides that no designated Office may disregard the priority claim concerned before giving the applicant an opportunity, upon entry into the national phase, to furnish the priority document within a time limit which is reasonable under the circumstances.

<u>Priority date</u>	<u>Priority application No.</u>	<u>Country or regional Office or PCT receiving Office</u>	<u>Date of receipt of priority document</u>
13 July 1999 (13.07.99)	11/198413	JP	04 Augu 2000 (04.08.00)
15 Octo 1999 (15.10.99)	11/293988	JP	04 Augu 2000 (04.08.00)
29 Octo 1999 (29.10.99)	11/308424	JP	04 Augu 2000 (04.08.00)
07 Dece 1999 (07.12.99)	11/347120	JP	04 Augu 2000 (04.08.00)

The International Bureau of WIPO
34, chemin des Colombettes
1211 Geneva 20, Switzerland

Facsimile No. (41-22) 740.14.35

Authorized officer

Sean Taylor

SAS

Telephone No. (41-22) 338.83.38

PATENT COOPERATION TREATY

19条2項第1号第1項第1号

11/28
添

PCT

From the INTERNATIONAL BUREAU

**NOTIFICATION CONCERNING
THE FILING OF AMENDMENTS OF THE CLAIMS**
(PCT Administrative Instructions, Section 417)

To:

NOMOTO, Yoichi
Terao-Building
7th floor
8-4, Nishi-Shinbashi 2-chome
Minato-ku
Tokyo 105-0003
JAPON

Date of mailing (day/month/year) 10 November 2000 (10.11.00)	
Applicant's or agent's file reference PCT-16069	IMPORTANT NOTIFICATION
International application No. PCT/JP00/03853	International filing date (day/month/year) 14 June 2000 (14.06.00)
Applicant NOK CORPORATION et al	

1. The applicant is hereby notified that amendments to the claims under Article 19 were received by the International Bureau on:

06 November 2000 (06.11.00)

2. This date is within the time limit under Rule 46.1.

Consequently, the international publication of the international application will contain the amended claims according to Rule 48.2(f), (h) and (i).

3. The applicant is reminded that the international application (description, claims and drawings) may be amended during the international preliminary examination under Chapter II, according to Article 34, and in any case, before each of the designated Offices, according to Article 28 and Rule 52, or before each of the elected Offices, according to Article 41 and Rule 78.

The International Bureau of WIPO
34, chemin des Colombettes
1211 Geneva 20, Switzerland

Facsimile No.: (41-22) 740.14.35

Authorised officer

Susumu Kubo

Telephone No.: (41-22) 338.83.38

(19) 世界知的所有権機関
国際事務局



(43) 国際公開日
2001 年 1 月 18 日 (18.01.2001)

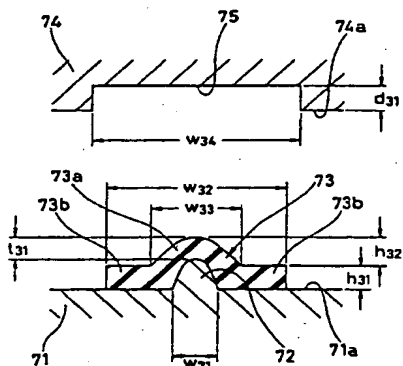
PCT

(10) 国際公開番号
WO 01/049883 A1

- (51) 国際特許分類: H01M 8/02, F16J 15/14 251-0042 神奈川県藤沢市辻堂新所町4-3-1 エヌオーケー株式会社内 Kanagawa (JP).
- (21) 国際出願番号: PCT/JP00/03853
- (22) 国際出願日: 2000 年 6 月 14 日 (14.06.2000)
- (25) 国際出願の言語: 日本語
- (26) 国際公開の言語: 日本語
- (30) 優先権データ:
特願平11/198413 1999 年 7 月 13 日 (13.07.1999) JP
特願平 11/293988
1999 年 10 月 15 日 (15.10.1999) JP
特願平 11/308424
1999 年 10 月 29 日 (29.10.1999) JP
特願平11/347120 1999 年 12 月 7 日 (07.12.1999) JP
- (71) 出願人 (米国を除く全ての指定国について): エヌオーケー株式会社 (NOK CORPORATION) [JP/JP]; 〒105-8585 東京都港区芝大門1丁目12番15号 Tokyo (JP).
- (72) 発明者: および
- (75) 発明者/出願人 (米国についてのみ): 長井 修 (NAGAI, Osamu) [JP/JP]. 若松重夫 (WAKAMATSU, Shigeo) [JP/JP]. 黒木雄一 (KUROKI, Yuichi) [JP/JP]; 〒
- (74) 代理人: 弁理士 野本陽一 (NNOMOTO, Yoichi); 〒105-0003 東京都港区西新橋2丁目8番4号 寺尾ビル7階 Tokyo (JP).
- (81) 指定国 (国内): AE, AL, AU, BA, L, BB, BG, BR, CA, CN, CR, CU, CZ, DM, EE, GD, GE, HH, HU, ID, IL, IN, IS, KP, KR, LC, LK, LR, LT, LV, MA, MG, MK, MN, MX, NO, NZ, PL, RO, SG, SI, SK, TR, T, TT, UA, US, UZ, VN, YU, ZA.
- (84) 指定国 (広域): ARIPO 特許 (GIGH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), ユーラシア特許 (AM, AZ, BY, KG, KZ, MD, RU, TJ, TNM), ヨーロッパ特許 (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI 特許 (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, S, SN, TD, TG).
- 添付公開書類:
— 国際調査報告書
— 補正書・説明書
- 2 文字コード及び他の略語については、定期発行される各 PCT ガゼットの巻頭に掲載されている「コードと略語のガイダンスノート」を参照。

(54) Title: GASKET FOR FUEL CELL AND METHOD OF FORMING IT

(54) 発明の名称: 燃料電池用ガスケットおよびその成形方法



(57) Abstract: A gasket for a fuel cell, wherein a gasket lip consisting of a liquid rubber hardened substance is formed in one piece α on the surface of a flat plate consisting of carbon, graphite, conductive resin such as conductive phenolic resin, ion exchange resin, or metal such as stainless steel and magnesium alloy, or in a groove formed in the above surface, whereby a seal portion thinning, assembling efficiency improving, position deviation preventing, surface pressure lowering, and surface pressure uniformizing can be attained.

WO 01/04983 A1

[続葉有]

特 許 協 力 条 約

P C T

国際予備審査報告

(法第12条、法施行規則第56条)
〔PCT36条及びPCT規則70〕

出願人又は代理人 の書類記号 PCT-16069	今後の手続きについては、国際予備審査報告の送付通知（様式PCT/ IPEA/416）を参照すること。	
国際出願番号 PCT/JPO0/03853	国際出願日 (日.月.年) 14.06.00	優先日 (日.月.年) 13.07.99
国際特許分類 (IPC) Int.Cl ⁷ H01M8/02、F16J15/14		
出願人 (氏名又は名称) エヌオーケー株式会社		

1. 国際予備審査機関が作成したこの国際予備審査報告を法施行規則第57条 (PCT36条) の規定に従い送付する。
2. この国際予備審査報告は、この表紙を含めて全部で <u>4</u> ページからなる。 <input checked="" type="checkbox"/> この国際予備審査報告には、附属書類、つまり補正されて、この報告の基礎とされた及び／又はこの国際予備審査機関に対してした訂正を含む明細書、請求の範囲及び／又は図面も添付されている。 (PCT規則70.16及びPCT実施細則第607号参照) この附属書類は、全部で <u>1</u> ページである。
3. この国際予備審査報告は、次の内容を含む。 I <input checked="" type="checkbox"/> 国際予備審査報告の基礎 II <input type="checkbox"/> 優先権 III <input type="checkbox"/> 新規性、進歩性又は産業上の利用可能性についての国際予備審査報告の不作成 IV <input type="checkbox"/> 発明の単一性の欠如 V <input checked="" type="checkbox"/> PCT35条(2)に規定する新規性、進歩性又は産業上の利用可能性についての見解、それを裏付けるための文献及び説明 VI <input checked="" type="checkbox"/> ある種の引用文献 VII <input type="checkbox"/> 国際出願の不備 VIII <input type="checkbox"/> 国際出願に対する意見

国際予備審査の請求書を受理した日 09.11.00	国際予備審査報告を作成した日 01.08.01	
名称及びあて先 日本国特許庁 (IPEA/JP) 郵便番号100-8915 東京都千代田区霞が関三丁目4番3号	特許庁審査官 (権限のある職員) 高木 康晴 電話番号 03-3581-1101 内線 3477	4X 9275

I. 国際予備審査報告の基礎

1. この国際予備審査報告は下記の出願書類に基づいて作成された。(法第6条(PCT14条)の規定に基づく命令に
 応答するために提出された差し替え用紙は、この報告書において「出願時」とし、本報告書には添付しない。
 PCT規則70.16, 70.17)

☐ 出願時の国際出願書類

☒ 明細書 第 1-32 ページ、 出願時に提出されたもの
 明細書 第 ページ、 国際予備審査の請求書と共に提出されたもの
 明細書 第 ページ、 付の書簡と共に提出されたもの

☒ 請求の範囲 第 1-22 項、 出願時に提出されたもの
 請求の範囲 第 23, 24 項、 PCT19条の規定に基づき補正されたもの
 請求の範囲 第 項、 国際予備審査の請求書と共に提出されたもの
 請求の範囲 第 項、 付の書簡と共に提出されたもの

☒ 図面 第 1-24 ページ/図、 出願時に提出されたもの
 図面 第 ページ/図、 国際予備審査の請求書と共に提出されたもの
 図面 第 ページ/図、 付の書簡と共に提出されたもの

☐ 明細書の配列表の部分 第 ページ、 出願時に提出されたもの
 明細書の配列表の部分 第 ページ、 国際予備審査の請求書と共に提出されたもの
 明細書の配列表の部分 第 ページ、 付の書簡と共に提出されたもの

2. 上記の出願書類の言語は、下記に示す場合を除くほか、この国際出願の言語である。

上記の書類は、下記の言語である _____ 語である。

- ☐ 国際調査のために提出されたPCT規則23.1(b)にいう翻訳文の言語
☐ PCT規則48.3(b)にいう国際公開の言語
☐ 国際予備審査のために提出されたPCT規則55.2または55.3にいう翻訳文の言語

3. この国際出願は、ヌクレオチド又はアミノ酸配列を含んでおり、次の配列表に基づき国際予備審査報告を行った。

- ☐ この国際出願に含まれる書面による配列表
☐ この国際出願と共に提出されたフレキシブルディスクによる配列表
☐ 出願後に、この国際予備審査(または調査)機関に提出された書面による配列表
☐ 出願後に、この国際予備審査(または調査)機関に提出されたフレキシブルディスクによる配列表
☐ 出願後に提出した書面による配列表が出願時における国際出願の開示の範囲を超える事項を含まない旨の陳述書の提出があった
☐ 書面による配列表に記載した配列とフレキシブルディスクによる配列表に記載した配列が同一である旨の陳述書の提出があった。

4. 補正により、下記の書類が削除された。

☐ 明細書 第 _____ ページ
☐ 請求の範囲 第 _____ 項
☐ 図面 図面の第 _____ ページ/図

5. ☐ この国際予備審査報告は、補充欄に示したように、補正が出願時における開示の範囲を越えてされたものと認められるので、その補正がされなかったものとして作成した。(PCT規則70.2(c) この補正を含む差し替え用紙は上記1.における判断の際に考慮しなければならない、本報告に添付する。)

V. 新規性、進歩性又は産業上の利用可能性についての法第12条(PCT 3.5条(2))に定める見解、それを裏付ける文献及び説明

1. 見解

新規性 (N)	請求の範囲	1-24	有
	請求の範囲		無
進歩性 (IS)	請求の範囲	13, 16-18, 21-24	有
	請求の範囲	1-12, 14, 15, 19, 20	無
産業上の利用可能性 (IA)	請求の範囲	1-24	有
	請求の範囲		無

2. 文献及び説明 (PCT規則70.7)

- 文献1 : 日本国実用新案登録出願56-13038号(日本国実用新案登録出願公開57-125746号)の願書に添付した明細書及び図面の内容を撮影したマイクロフィルム(株式会社スリーボンド)5.8月.1982(05.08.82), 全文(ファミリーなし)
- 文献2 : JP 08-37012 A(富士電機株式会社)6.2月.1996 (06.02.96), 図1の72, 613 (ファミリーなし)
- 文献3 : JP 58-155670 A(株式会社日立製作所)16.9月.1983 (16.09.83), 図3 (ファミリーなし)
- 文献4 : EP 671575 A2 (TOYOTA JIDOSHA KABUSHIKIKAISHA) 13.09.1995 (13.09.95) FIG 14 & JP07-137085A

請求の範囲1-12, 14, 15に記載された発明は、国際調査報告で引用された文献1-3より進歩性を有しない。文献2, 3には、[燃料電池の平面プレートに施された溝部に、ガスケットを設けること]が記載され、また、[ガスケットとして1000~2000PSの液状ゴム硬化物よりなるもの]は、文献1に記載されているように、ガスケットとして周知の部材であるから、文献2, 3のガスケットとして1000~2000PSの液状ゴム硬化物よりなるものを用いることは、当業者であれば容易に想到し得たことである。また、文献1のガスケットは、断面が山形であり、ガスケットをガスケットリップを備えたものとし、形状、高さを適宜設定することは、当業者であれば格別創意工夫を要したこととはいえない。

請求の範囲19, 20に記載された発明は、国際調査報告で引用された文献2-4より進歩性を有しない。文献2, 3には、[燃料電池の平面プレートに施された溝部に、ガスケットを設けること]が記載され、また、上下金型の隙間を真空引きし、型締めしてガスケットリップを形成することは、文献4に記載されているように公知の技術事項であるから、文献2, 3において、上下金型の隙間を真空引きし、型締めしてガスケットリップを形成することは、当業者であれば容易に想到し得たことである。

VI. ある種の引用文献

1. ある種の公表された文書 (PCT規則70.10)

出願番号 特許番号	公知日 (日. 月. 年)	出願日 (日. 月. 年)	優先日 (有効な優先権の主張) (日. 月. 年)
JP10-243094 「EX」	(14. 03. 00)	(28. 8. 98)	

2. 書面による開示以外の開示 (PCT規則70.9)

書面による開示以外の開示の種類	書面による開示以外の開示の日付 (日. 月. 年)	書面による開示以外の開示に言及している 書面の日付 (日. 月. 年)
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SPECIFICATION

TITLE OF THE INVENTION

GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME

TECHNICAL FIELD

The present invention relates to a gasket for a fuel battery and a method of forming the same.

BACKGROUND ART

For example, as shown in Fig. 24, a fuel battery has flat plates such as collector electrodes (separators) 2, an ion exchange membrane 3 held between them, membrane fixing reaction electrodes 4 fixed to the ion exchange membrane 3 and the like, and these constituting elements are combined, whereby a fuel battery cell 1 is constituted. As a material of the flat plates, a graphite or the like is employed in addition to a carbon, and further, a conductive resin such as a conductive phenol, an ion exchange resin, a metal such as a stainless steel, a magnesium alloy or the like, and the like may be employed.

With respect to a seal for the fuel battery cell 1 and a seal between the respective constituting elements, since a lot of seals are used for laminating a lot of cells 1, it is possible to make a product itself compact by using a seal material which is as thin or narrow as possible.

Further, there have been conventionally known a structure using a single gasket (refer to Japanese Unexamined Patent Publication No. 9-231987, 7-226220 or 7-153480), a structure in which a foamed sponge layer 6 is overlapped on a rubber plate 5 as illustrated so as to utilize as a gasket (refer to Japanese Unexamined Patent Publication No. 7-312223) and the like, however, these prior arts do not correspond to a structure intending to achieve objects of making the seal portion thin, improving an assembling property, preventing a position shift, making a surface pressure low, making the surface pressure uniform and the like, that is, these conventional separated type gasket has a disadvantage which can not sufficiently satisfy the points of making the seal portion thin, improving the assembling property, preventing the position shift, making the surface pressure low, making the surface pressure uniform and the like, and further, there is a risk that a problem in an assembling process, a malfunction due to a mis-assembling, a functional unstableness or the like is generated.

That is, in the case of a normal separated type gasket, although the low surface pressure, the uniform surface pressure and the like can be achieved, it has been impossible to simultaneously satisfy the thinness

of seal, the position shift prevention at a time of assembling and the like.

Further, in the case of forming the gasket in accordance with the known forming method, a weld defect is easily generated in a terminal end portion of a material flow passage, so that it is hard to form a lip in the portion in correspondence to a shape of a metal mold, and this becomes the worst reason for obstructing a sealing performance.

Accordingly, in order to prevent the problems mentioned above, a vacuum forming is generally executed, and, in the conventional vacuum forming methods, there are a method of executing an evacuation by providing an evacuation passage in the middle of a material flow passage, and a method of executing an evacuation by surrounding a whole of a metal mold by a vacuum chamber.

However, in the former method, since there is a case that a low viscosity material corresponding to a forming material for a gasket flows in the evacuating passage, there is a problem that a stable formation of the gasket is obstructed. Further, in the latter method, there is a problem that a structure of the metal mold portion is necessarily complex and expensive, and further, there is a problem that an evacuating capacity becomes too much so as to give a bad influence to a cycle

time.

The present invention is made by taking the points mentioned above into consideration, and an object of the present invention is to provide a gasket used for a fuel battery which can solve the problems with respect to making a seal portion thin, improving an assembling property, preventing a position shift, making a surface pressure low, making the surface pressure uniform, and the like, and a method of forming such the gasket, and another object of the present invention is to provide a method of forming a gasket which can stably form the gasket, has a comparatively simple structure of a metal mold apparatus and has a comparatively short cycle time.

DISCLOSURE OF THE INVENTION

In order to achieve the object mentioned above, a gasket for a fuel battery in accordance with the present invention is characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a flat plate made of a carbon, a graphite, a conductive resin such as a conductive phenol resin or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, or a groove portion applied to the surface, and in correspondence thereto, in accordance with a first aspect of the present invention, there is provided

a gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a flat plate or a groove portion applied to the surface.

Further, in accordance with a second aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that the flat plate is a collector electrode, an ion exchange membrane or a membrane fixing reaction electrode.

Further, in accordance with a third aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that the liquid rubber hardened material has a hardness of (JIS A) 60 or less.

Further, in accordance with a fourth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the third aspect mentioned above, characterized in that the hardness (JIS A) of the liquid rubber hardened material is preferably between 5 and 50 and more preferably between 10 and 40.

Further, in accordance with a fifth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a viscosity ($\text{Pa} \cdot \text{s}$) (25 degrees

Celsius)) of the liquid rubber is between 30 and 10,000 and preferably between 30 and 2,000.

Further, in accordance with a sixth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a cross sectional shape of the gasket lip made of the liquid rubber hardened material is a trapezoidal shape or a chevron shape.

Further, in accordance with a seventh aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a cross sectional shape of the gasket made of the liquid rubber hardened material is provided with a portion having a trapezoidal cross section or a portion having a chevron cross section.

Further, in accordance with an eighth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a seal portion of the gasket lip has a circular arc cross sectional shape.

Further, in accordance with a ninth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the eighth aspect mentioned above, characterized in that the seal portion has a height of substantially 0.2 to 1.5 mm.

Further, in accordance with a tenth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that the seal portion of the gasket lip has a chevron cross sectional shape, a convex cross sectional shape or a triangular cross sectional shape.

Further, in accordance with an eleventh aspect of the present invention, there is provided a gasket for a fuel battery as recited in the tenth aspect mentioned above, characterized in that the seal portion has a height of substantially 0.3 to 1.5 mm.

Further, in accordance with a twelfth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the tenth aspect mentioned above, characterized in that a front end portion of the seal portion has a circular arc cross sectional shape.

Further, in accordance with a thirteenth aspect of the present invention, there is provided a gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on the surface, a pair of the gasket lips arranged so as to hold an electrolyte membrane portion between them are formed so as to have different cross sectional shapes, and a flat surface portion provided with a

predetermined width being in contact with the electrolyte membrane portion is formed in one of the gasket lips.

Further, in accordance with a fourteenth aspect of the present invention, there is provided a gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on the surface, a flat surface portion provided with a predetermined width being in contact with an electrolyte membrane portion is formed in at least one of a pair of the gasket lips arranged so as to hold the electrolyte membrane portion between them.

Further, in accordance with a fifteenth aspect of the present invention, there is provided a gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on the surface, and a flat surface portion provided with a predetermined width being in contact with an ion exchange membrane is formed in at least one of a pair of gasket lips arranged so as to hold the ion exchange membrane between them.

Further, in accordance with a sixteenth aspect of the present invention, there is provided a gasket for

a fuel battery as recited in the first aspect mentioned above, characterized in that a projection along a gasket lip line is provided in the flat surface plate, and the gasket lip is formed so as to cover the projection.

Further, in accordance with a seventeenth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a projection along a gasket lip line is provided in the flat surface plate, an adhesive agent is applied around the projection, and the gasket lip is formed so as to cover the area.

Further, in accordance with an eighteenth aspect of the present invention, there is provided a gasket for a fuel battery as recited in the first aspect mentioned above, characterized in that a projection along a gasket lip line is provided in the flat surface plate, an adhesive agent is not applied around the projection, and the gasket lip is formed so as to cover the area.

Further, in accordance with a nineteenth aspect of the present invention, there is provided a method of forming a gasket for a fuel battery as recited in any one of the first aspect to the eighteenth aspect mentioned above, characterized in that a gap is provided

between upper and lower molds before injecting so as to evacuate, and thereafter the molds are clamped so as to injection mold the gasket lip.

Further, in accordance with a twentieth aspect of the present invention, there is provided a method of forming a gasket for a fuel battery as recited in the nineteenth aspect mentioned above, characterized in that a through hole open to both surfaces of the flat plate or bottom surfaces of groove portions applied to the both surfaces is provided, and the gasket lip is integrally formed in the both surfaces or both groove portions through the through hole simultaneously.

Further, in accordance with a twenty first aspect of the present invention, there is provided a gasket for a fuel battery, characterized in that a pair of groove portions are provided so as to respectively correspond to both surfaces of a substrate, a communication hole is provided in the substrate so as to communicate a pair of groove portions, an elastomer is charged into a pair of groove portions and the communication hole, a convex seal lip is provided in the elastomer, the communication hole is arranged at a position biasing to one side in a width direction of the groove portion, and the convex seal lip is arranged at a position biasing to an opposite side.

Further, in accordance with a twenty second aspect of the present invention, there is provided a method of forming a gasket for a fuel battery integrally provided with a seal lip constituted by an elastomer on both surfaces of a substrate, characterized in that a communication hole communicating between seal lip forming cavities formed between metal molds engaged and aligned with both surfaces of the substrate is provided in the substrate, the communication hole is formed at a position corresponding to a gate open to one of the both seal lip forming cavities with a larger diameter than that of the gate, and a forming material supplied from the gate is charged into the both seal lip forming cavities via the communication hole.

The gasket for the fuel battery in accordance with the first aspect of the present invention provided with the structure mentioned above is structured, in order to solve the problems in the conventional art, such that the gasket lip made of the liquid rubber hardened material corresponding to the low viscosity material is integrally formed on the surface of the flat plate constituted by the collector electrode, the ion exchange membrane, the membrane fixing reaction membrane (refer to the second aspect) or the like, whereby it is intended to make the seal portion thin, improve an assembling

property, prevent a position shift, reduce a surface pressure and make the surface pressure uniform. Further, in the case that the gasket lip made of the liquid rubber hardened material corresponding to the low viscosity material is integrally formed in the groove portion applied to the surface of the flat plate, since the gasket lip is integrally formed not only on the bottom surface of the groove portion but also on the side surface, it is possible to further improve a fixing property. The liquid rubber hardened material is employed for the forming material of the gasket lip as mentioned above, and it is preferable that the hardness (JIS A) of the liquid rubber hardened material is set to be 60 or less, preferably between 5 and 50 and more preferably between 10 and 40 (refer to the third and fourth aspects). Further, in the fuel battery in which the flat plates are laminated via a multiplicity of gaskets, by using the low hardness rubber, it is possible to seal with a low fastening pressure, it is possible to prevent the flat plate from being damaged, and it is possible to absorb an unevenness on an opposing surface to the gasket. The low viscosity material preferably employs a viscosity between 30 and 10,000 Pa · s (25 degrees Celsius), preferably between 30 and

2,000 Pa · s (25 degrees Celsius), and for example, it is possible to use a silicon rubber, a fluorine-contained rubber, a nitrile rubber, an ethylene propylene rubber or the like respectively in a liquid phase. Further, since it is possible to increase a fluidity of the rubber so as to reduce an injection pressure by employing the low viscosity material as mentioned above, it is possible to reduce a damage and a deformation of the flat plate due to a forming pressure at a time of injection molding (refer to the fifth aspect).

Further, as in the gasket for the fuel battery in accordance with the thirteenth aspect of the present invention, when a pair of gasket lips are formed so as to have different shapes and the flat surface portion is provided in one of them, the flat portion forms a receiving side among a pair of seal portions constituted by a pair of gasket lips and a area of the receiving side is set to be comparatively wide by a width of the flat portion, so that it is possible to enlarge an allowable range of position shift from a medium value with respect to a closely contact position of another gasket lip. A combination of the gasket lip preferably employs a combination between a trapezoidal cross section corresponding to the receiving side and a

chevron cross section in an opposite side, and preferably employs a combination between a cross sectional shape provided with a trapezoidal cross sectional portion and a cross sectional shape provided with a chevron cross sectional portion.

Further, it is preferable that the seal portion of the gasket lip has a circular arc cross sectional shape, and the seal portion in this case preferably has a height of substantially 0.2 to 1.5 mm. Further, it is preferable that the seal portion of the gasket lip has a chevron cross sectional shape, a convex cross sectional shape or a triangular cross sectional shape, it is preferable that a height of the seal portion in this case is between substantially 0.3 and 1.5 mm, and it is further preferable that a front end portion of the seal portion is formed in a circular arc cross sectional shape.

Further, as in the gasket for the fuel battery in accordance with the fourteenth aspect or the fifteenth aspect of the present invention, when the flat portion is formed in at least one of a pair of gasket lips arranged so as to hold the electrolyte membrane portion or the ion exchange membrane between them, it is also possible to enlarge the allowable range of position shift in the same manner and it is possible to stabilize the contact

of the gasket lip.

Further, in the case of forming the gasket lip by using the liquid rubber hardened material as mentioned above, a liquid injection molding apparatus is used as a molding apparatus, and at a time of injection molding the gasket lip by using the liquid injection molding apparatus, the metal mold is held so that a gap equal to or less than 2 mm is kept between the upper and lower metal molds immediately before the injection, and a portion between the upper and lower metal molds is sealed by using a seal member such as an O-ring or the like (refer to S101, in Fig. 3. Same Fig. will be referred hereunder). Next, a nozzle touch is executed and a material inflow port is closed so as to form a sealed space shut out from an ambient air within the metal mold (S102). Next, an evacuation is executed via evacuation holes provided at one or a plurality of portions on a metal mold parting surface, and in order to prevent the material from being sucked from the nozzle and flowing into a cavity at this time, a shut-off valve is provided in the nozzle so as to prevent the material from flowing in (S103). Next, a mold clamping is completely executed at a stage that it is judged that the evacuation reaches a desired degree of vacuum (S104), the material is injected within the cavity in which the degree of vacuum

is maintained (S105), and the gasket lip is formed (the nineteenth aspect).

The method of forming the gasket for the fuel battery in accordance with the nineteenth aspect mentioned above is structured such that the gasket lip made of the liquid rubber hardened material corresponding to the low viscosity material is integrally formed on one surface or both surfaces of the flat plate, however, when it is tried to form the gasket lip one side by one side in the case that it becomes necessary to provide the gasket lip on both surfaces of the thin plate, there is a case that an opposite side becomes in a floating state and cracks due to the molding pressure or a burr is generated due to deflection. Further, it is possible to consider a method of providing a convex portion in a lower mold so as to support a groove portion on a back surface, however, it is necessary to manufacture another mold in the case that the groove shape is different between front and back surfaces, whereby it is impossible to avoid a cost increase and a mold structure becomes very complex. Taking into consideration the matter that the height fluctuates on the basis of a metal mold working tolerance and a plate groove depth tolerance, there is a case that it is hard to maintain a stable molding. Accordingly, in the

forming method in accordance with the twentieth aspect of the present invention, the structure is made such that the through hole open to both surfaces of the flat plate is provided, and the gasket lips are integrally formed on both surfaces of the flat plate via the through hole simultaneously, or the through hole open to the bottom surfaces of the groove portions applied to both surfaces of the flat plate is provided, and the gasket lips are integrally formed in both groove portions via the through hole simultaneously.

Further, the gasket for the fuel battery in accordance with the sixteenth aspect of the present invention is structured as follows.

That is, the gasket for the fuel battery in accordance with the first aspect mentioned above is structured such that the gasket lip is directly formed on the flat plate, and, for the purpose of preventing a lateral shift, the larger bottom width than the lip width is provided, the adhesion treatment is applied or the groove portion is formed on the flat plate and the gasket is formed so as to cover it. However, in the case that the larger bottom width mentioned above is provided, it inevitably accompany the incurrence of a waste of the material and the space. Further, with respect to the holding operation by the adhesive agent,

an influence that the adhesive agent gives to a power generating efficiency is not clear at present, and taking into consideration a risk of a bad influence applied due to a long time use, a gasket which can satisfy a performance without the adhesion treatment is desired. Further, in the case of forming the groove portion for preventing the lateral shift on the flat plate and forming the gasket lip so as to cover it, a strength of the plate is reduced thereby, and the contact pressure at a time of assembling is reduced in correspondence to a depth of the groove portion, so that it is necessary to form the gasket lip having a larger size in consideration thereof, whereby a greater strain is applied to the gasket at a time of assembling and there is a risk that a durability is reduced. Accordingly, in the gasket for the fuel battery in accordance with the sixteenth aspect of the present invention, the structure is made such that the projection is provided along the lip line of the flat plate and the projection is covered by the gasket lip, whereby it is possible to prevent the position shift, it is possible to secure the seal surface pressure with a low strain amount and it is possible to secure a durability. Further, as in the gasket in accordance with the seventeenth aspect, the structure can be made such that the adhesive agent

is applied as occasion demands, and the gasket lip is formed so as to cover it. It is not always necessary to apply the adhesive agent (refer to the eighteenth aspect). The projection is preferably formed in a triangular cross sectional shape or a trapezoidal cross sectional shape of which a gap between the projection and the opposing member is secured to be equal to or more than 0.2 mm at a time of being assembled, and it is preferable that the projection is covered by the gasket lip having a thickness of 1.0 mm or less.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a schematic view of a liquid injection molding apparatus used for executing a method of forming a gasket in accordance with a first embodiment of the present invention;

Fig. 2 is a detailed schematic view of a metal mold in the apparatus;

Fig. 3 is a control flow chart of the apparatus;

Fig. 4 is a schematic view of a liquid injection molding apparatus used for executing a method of forming a gasket in accordance with a second embodiment of the present invention;

Fig. 5A is a cross sectional view of a main portion of a porous member showing a state before forming the gasket;

Fig. 5B is a cross sectional view of a main portion of a porous member showing a state after forming the gasket;

Fig. 6 is a cross sectional view of a gasket in accordance with a third embodiment of the present invention;

Fig. 7 is an enlarged view of a main portion in Fig. 6;

Fig. 8 is a cross sectional view of a main portion of a gasket in accordance with a fourth embodiment of the present invention;

Fig. 9 is a cross sectional view of a gasket in accordance with a fifth embodiment of the present invention;

Fig. 10 is an enlarged view of a main portion in Fig. 9;

Fig. 11 is a cross sectional view of a main portion showing a modified embodiment of a structure of the gasket;

Fig. 12 is a cross sectional view of a main portion showing a modified embodiment of the structure of the gasket;

Fig. 13 is a cross sectional view of a main portion of a gasket in accordance with a sixth embodiment of the present invention;

Fig. 14 is a cross sectional view of a main portion showing a modified embodiment of a structure of the gasket;

Fig. 15 is a cross sectional view of a main portion showing a modified embodiment of the structure of the gasket;

Fig. 16 is a cross sectional view of a main portion showing a modified embodiment of the structure of the gasket;

Fig. 17 is a cross sectional view of a main portion of a gasket in accordance with a seventh embodiment of the present invention;

Fig. 18 is a cross sectional view of a main portion showing a modified embodiment of a structure of the gasket;

Fig. 19 is a cross sectional view of a main portion showing a modified embodiment of the structure of the gasket;

Fig. 20 is a cross sectional view of a main portion showing a modified embodiment of the structure of the gasket;

Fig. 21 is a schematic cross sectional view of a bipolar plate for a fuel battery provided with a gasket formed by a manufacturing method in accordance with an eighth embodiment of the present invention;

Fig. 22 is a schematic view of a metal mold structure for forming the gasket;

Fig. 23 is a table showing a result of comparative test of the manufacturing method; and

Fig. 24 is a schematic view showing an embodiment of a structure of a fuel battery.

BEST MODE FOR CARRYING OUT THE INVENTION

Next, a description will be given of embodiments in accordance with the present invention with reference to the accompanying drawings.

First embodiment

Fig. 1 shows a liquid injection molding apparatus 11 used for executing a method of forming a gasket in accordance with a first embodiment of the present invention. A gasket (also refer to a gasket lip or a gasket main body) is formed by injecting a molding material supplied from a base resin tank 12, a coloring agent tank 13 and a setting agent tank 14 to an injection apparatus 16 via a material supplying plunger 15, into a metal mold 17 from the injection apparatus 16. The injection apparatus 16 is provided with a screw 20 driven in accordance with an operation of a hydraulic motor 18 and an injection cylinder 19, and an injection cylinder 21 within which the screw 20 is inserted, and a shut-off valve 23 preventing an inflow of the molding

material is arranged within a nozzle 22 at a front end of the injection cylinder 21 so as to be freely opened and closed. Further, an evacuation apparatus 24 constituted by a vacuum pump is connected to the metal mold 17.

Fig. 2 shows details of the metal mold 17. An upper platen 25, a heat insulating plate 26, an upper heating plate 27, an upper mold 28, a middle mold 29, a lower mold 30, a lower heating plate 31, a heat insulating plate 32 and a lower platen 33 are laminated in this order. A parting surface 34 of the upper mold 28 and the middle mold 29 is sealed by an O-ring 35 attached to an attaching groove 29a on an upper surface of the middle mold 29, a parting surface 36 of the middle mold 29 and the lower mold 30 is sealed by an O-ring 37 attached to an attaching groove 30a on an upper surface of the lower mold 30, and a sealed space 38 sealed by the O-rings 35 and 37 is evacuated by the evacuation apparatus 24. Further, a cavity space 39 is provided on an upper surface of the lower mold 30, a molding material is charged within a groove portion (also referred as a working groove) 40a or a recess portion formed on an upper surface (one surface) of a flat plate porous carbon member (also referred as a plate or a flat plate) 40 previously placed in the cavity space 39 from the injection apparatus 16

via a spool 41, a runner 42 and a gate 43, whereby a gasket (also referred as a gasket lip) is formed, and the gasket is integrally formed with the carbon member 40 at the same time of molding. The carbon member 40 is particularly constituted by the collector electrodes (separators) 2 of the fuel battery, the ion exchange membranes 3 held between them, the membrane fixing reaction electrode 4 fixed to the ion exchange membranes 3, or the like as mentioned above, and a graphite or the like may be employed for the material thereof in addition to the carbon. In this case, the groove portion 40a aims to strengthen an adhesive force of the gasket and prevent the position shift, and is not always required in the case that an adhesive property between the carbon member 40 and the gasket can be secured, and in the case that there is no risk that the position shift is generated due to an internal pressure at a using time.

Fig. 3 shows a control flow for an injection molding. In a mold clamping process, at first, a mold clamping is temporarily stopped at a previously set position (S101). During the temporary stop of the mold clamping, a distance between the metal molds is kept constant by using a holding means of a mold clamping position, and the distances between the molds are set so that the O-ring 35 held by the middle mold 29 and the O-ring 37 held

by the lower mold 30 are in contact with the upper mold 28 and the middle mold 29 respectively while the middle and upper molds 29, 28 and the lower and middle molds 30, 29 have not been completely closed yet and have intervals within 2mm respectively, whereby the ambient air does not flow into the sealed space 38 in the next evacuating process. Next, the nozzle 22 is moved forward at a time when the temporary stop of the mold clamping is completed so as to be touched with the upper mold 28 (S102). It is necessary to set a nozzle touch force to a level so that a leakage is not generated during the evacuation within the cavity space 39, however, the nozzle touch force may be generally equal to or more than 2 kN, whereby the other flow passages than the flow passage by which the cavity space 39 is connected to the evacuation apparatus 24 are completely shut down from the ambient air.

After the nozzle touch force is increased and a limit switch is operated, or at a stage that a predetermined time has elapsed from a time when the nozzle 22 starts moving forward, the evacuation apparatus 24 is operated so as to start evacuating (S103). In this case, a shut-off valve is provided within the nozzle 22 and the shut-off valve is closed, so as to prevent the material from being sucked from the nozzle

22 at an evacuating time so as to flow into the cavity 39.

Then, a mold clamping is executed by a high pressure at a time of reaching a previously set elapsed time (for example, 15 seconds or less) after starting the evacuation (S104) or a previously set degree of vacuum (for example, 10 Torr or less). The high mold clamping pressure at this time is equal to or less than a compression rupture strength of the carbon material 40 or less, and is desirably set to a pressure at which the carbon material 40 does not rupture and no burr is generated even in the case that the charging pressure is applied. For example, with respect to a structure in which a groove 40a (having a width 3.0 mm and a depth 0.3 mm) is worked on a surface of a carbon material (IKC-33 manufactured by TOYO CARBON) 40 of a resin impregnation type cut so as to have a shape and a thickness (2 mm) suitable for the separator for the fuel battery, it is desirable to restrict to be equal to or less than 10 kgf/mm².

Further, a liquid rubber hardened material in which a viscosity before hardening is 150 Pa · s (25 degrees Celsius) and a hardness (JIS A) after hardening is 20, for example, a liquid silicon rubber KE1950-20 (A ·

B) manufactured by SHINETSU CHEMICAL is good for the molding material, and the hardened material is obtained by controlling the temperature to a temperature at which the hardening is not progressed within the injection cylinder 21, that is, a temperature equal to or less than 25 degrees Celsius in the embodiment, and injecting to the metal mold a temperature of which is controlled to a hardening temperature 120 degrees Celsius to 180 degrees Celsius capable of obtaining a desired hardened material, 150 degrees Celsius in the embodiment. The injection pressure at this time is 200 kgf/cm², in the embodiment, and the hardening time is 150 seconds.

Further, since the gasket formed in the manner mentioned above corresponds to a structure obtained by integrally forming the gasket made of the low viscosity material with the groove portion 40a formed on the surface of the flat plate porous carbon member 40 such as the collector electrode 2, the ion exchange membrane 3, the membrane fixing reaction membrane 4 or the like, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform which are the conventional problems, and further it is possible to realize reducing a number of the parts, preventing the position shift

under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, reducing a burr leakage and the like.

Second embodiment

In a second embodiment in accordance with the present invention shown in Fig. 4, groove portions 40a and 40b are formed so as to correspond to each other on an upper surface and a lower surface of a flat surface plate porous carbon member 40 previously placed in a cavity space 39, and as shown in Fig. 5A in an enlarged manner, the groove portions 40a and 40b are communicated with each other via a through hole (also referred as a communication hole) 40c open to a bottom surface of each of the groove portions 40a and 40b. The through hole 40 is structured, for example, a plurality of through holes having a diameter of 1 mm are formed at an interval between 10 and 20 mm.

Accordingly, when the molding material of the gasket is supplied to the carbon member 40, as shown

in Fig. 5B, the gaskets 7 and 8 are integrally formed with both of the groove portions 40a and 40b via the through hole 40c simultaneously, whereby it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, directly molding the gasket on both surfaces of the thin plate, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, preventing a plate crack, reducing a burr leakage and the like.

The gaskets 7 and 8 respectively integrally have base portions (charging portions) 7a and 8a having a rectangular cross sectional shape and charged within the groove portions 40a and 40b, and seal parts (seal portions) 7b and 8b having a circular arch cross

sectional shape and protruding from the groove portions 40a and 40b so as to be closely contact with an opposing member, and they are integrally formed via a rubber hardened material 9 within the through hole 40c. In the respective gaskets 7 and 8, a width w1 of the base portions 7a and 8a, that is, a width w1 of a whole of the gaskets 7 and 8 is substantially 1.5 to 5 mm at actual size, a width w2 of the seal portions 7b and 8b is substantially 1 to 4 mm at actual size, and a height h1 of the seal portions 7b and 8b is substantially 0.2 to 1.5 mm at actual size, respectively. The other structures and the other operations and effects of the gasket and the forming method thereof in accordance with the present invention are the same as those of the first embodiment mentioned above. Further, the groove portions 40a and 40b may be omitted in the same manner, and in this case, the through hole 40c is directly open on both of the upper and lower surfaces of the carbon member 40.

Third embodiment

Next, Fig. 6 shows a cross section of a gasket for a fuel battery in accordance with a third embodiment of the present invention. This gasket is structure in the following manner.

That is, at first, an electrolyte membrane 55 is

arranged between a pair of electrodes (also referred as outer electrodes) 52 and 53, and electrodes (also referred as inner electrodes) 59 and 60 are respectively arranged between the respective electrodes 52 and 53 and the electrolyte membrane 55, whereby a fuel battery cell 51 constituted by a five-layer laminated body made by arranging the electrode 52, the electrode 59, the electrolyte membrane 55, the electrode 60 and the electrode 53 mentioned above in this order is formed.

A pair of electrodes 52 and 53 respectively correspond to the collector electrodes (the separators) mentioned above, are formed by a carbon plate, with a thickness t_1 of about 1 to 2 mm at actual size.

The electrolyte membrane 55 corresponds to the ion exchange membrane mentioned above, and is combined with an electrolyte membrane protecting membrane 56 at an end portion in a plane direction, and an electrolyte membrane portion 54 is formed by a combination of the electrolyte membrane 55 and the electrolyte membrane protecting membrane 56. The electrolyte membrane protecting membrane 56 has a pair of constituting parts 57 and 58 gripping the end portion in the plane direction of the electrolyte membrane 55 between them, and a pair of constituting parts 57 and 58 respectively integrally have laminating portions 57a and 58a laminated with each

other and gripping portions 57b and 58b gripping the end portion in the plane direction of the electrolyte membrane 55 between them. A thickness t_2 of the electrolyte membrane protecting membrane 56 at the laminating portions 57a and 58a of a pair of constituting parts 57 and 58 is about 0.1 to 0.2 mm at actual size.

Further, the electrodes 59 and 60 respectively correspond to the membrane fixing reaction electrodes mentioned above, and are formed by a carbon so as to form a gas flow passage. A thickness t_3 of a three-layer laminated body constituted by a pair of electrodes 59 and 60 and the electrolyte membrane 55 is about 0.5 to 1.5 mm at actual size.

Gaskets (also referred as gasket lips or seal members) 61 and 62 made of a low viscosity material are integrally formed on opposing surfaces to each other of a pair of electrodes 52 and 53 so as to correspond to each other, and the electrolyte membrane protecting membrane 56 of the electrolyte membrane portion 54 is held between a pair of gaskets 61 and 62, at the laminated portions 57a and 58a of a pair of constituting parts 57 and 58 in an unbonded manner, whereby the seal portion is formed.

As shown in Fig. 7 in an enlarged manner, one gasket 61 among a pair of gaskets 61 and 62 is formed as a wholly

trapezoidal cross sectional structure by forming a flat surface portion (also referred as a flat portion) 61a at a front end portion thereof, and the plate surface portion 61a is provided with a predetermined width w_3 . Further, another gasket 62 is formed as a wholly chevron cross sectional structure, a wholly convex cross sectional structure or a wholly triangular cross sectional structure by forming a front end portion 62a in a circular arc cross sectional shape, and is formed so that a width w_4 of the front end portion 62a is smaller than the width w_3 of the flat surface portion 61a of one gasket 61. One gasket 61 integrally has a rectangular cross sectional base portion 61c and a trapezoidal cross sectional seal portion 61d integrally formed on a flat surface of the base portion 61c, and the flat surface portion 61a is formed in the seal portion 61d. A width w_5 of the base portion 61c, that is, a whole width w_5 of the gasket 61 is substantially 2 to 5 mm at actual size, the width w_3 of the flat surface portion 61a is substantially 1 to 4 mm at actual size, a height h_2 of a whole of the gasket 61 is substantially 0.3 to 1 mm at actual size, and a height h_3 of the seal portion 61d is substantially 0.1 to 0.5 mm at actual size. Another gasket 62 integrally has a rectangular cross sectional base portion 62c and a chevron cross

sectional, a convex cross sectional or a triangular cross sectional seal portion 62d integrally formed on a flat surface of the base portion 62c, and the circular arc cross sectional front end portion 62a is formed in the seal portion 62d. A width w6 of the base portion 62c, that is, a width w6 of a whole of the gasket 62 is substantially 2 to 5 mm at actual size, a width w7 of the seal portion 62d is substantially 1 to 3 mm at actual size, a height h4 of a whole of the gasket 62 is substantially 0.5 to 1.5 mm at actual size, a height h5 of the base portion 62c is substantially 0.2 to 0.5 mm at actual size, and a radius of the circular arc of the front end portion 62a is substantially 0.1 to 0.5 mm at actual size, respectively. Further, a lip front end angle α can be optionally set, however, is preferably about 40 to 130 degrees, and more preferably about 40 to 90 degrees. Further, both of the gaskets 61 and 62 are respectively formed of a silicon rubber having a low hardness.

Since the gasket provided with the structure mentioned above is structured such that the gaskets 61 and 62 made of the silicon rubber corresponding to the liquid rubber hardened material are integrally formed on the surfaces of a pair of electrodes 52 and 53 corresponding to the flat surface plate porous member,

and the rubber is integrally formed with the plate at the same time of forming, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, reducing a burr leakage and the like.

Further, since the cross sectional shapes of a pair of gaskets 61 and 62 are made different from each other and the flat surface portion 61a is provided in one gasket 61, the flat surface portion 61a forms a receiving side among a pair of seal portions of a pair of gaskets 61 and 62, and a area of the receiving side is set to be comparatively wide by the width w_1 of the flat surface portion 61a. Accordingly, it is possible to enlarge an allowable range of the position shift from a medium

value with respect to the closely contact position with the opposing member (the electrolyte membrane portion 54) of another gasket 62, whereby it is possible to sufficiently secure a necessary sealing property even when the position shift is rather great.

Fourth embodiment

Further, as shown in Fig. 8, the structure may be made such that respective parts of both gaskets 61 and 62 are inserted into groove portions 52a and 53a provided on the surfaces of the electrodes 52 and 53 in addition to the structure mentioned above, and in such the case, it is possible to make a distance between a pair of electrodes 52 and 53 shorter, whereby it is possible to make the laminated body or the fuel battery compact in a thickness direction. Here, in this case, one gasket 61 integrally has a rectangular cross sectional base portion 61c charged in the groove portion 52a and a trapezoidal cross sectional seal portion 61d integrally formed on a flat surface of the base portion 61c, and the flat surface portion 61a is formed in the seal portion 61d. A width w_5 of the base portion 61c, that is, a whole width w_5 of the gasket 61 is substantially 2 to 5 mm at actual size, the width w_3 of the flat surface portion 61a is substantially 1 to 4 mm at actual size, a height h_6 of the base portion 61c is substantially

0.1 to 0.5 mm at actual size, and a height h_3 of the seal portion 61d is substantially 0.1 to 0.5 mm at actual size. Further, another gasket 62 integrally has a rectangular cross sectional base portion 62c charged in the groove portion 53a, and a chevron cross sectional seal portion 62d integrally formed on a flat surface of the base portion 62c, and the circular arc cross sectional front end portion 62a is formed in the seal portion 62d. A width w_6 of the base portion 62c, that is, a width w_6 of a whole of the gasket 62 is substantially 2 to 5 mm at actual size, a width w_7 of the seal portion 62d is substantially 1 to 3 mm at actual size, a height h_5 of the base portion 62c is substantially 0.2 to 0.5 mm at actual size, a height h_7 of the seal portion 62d is substantially 0.3 to 1.2 mm at actual size, and a radius of the circular arc of the front end portion 62a is substantially 0.1 to 0.5 mm at actual size, respectively.

Fifth embodiment

The gaskets for the fuel battery in accordance with the third and fourth embodiments mentioned above are structured such that the electrolyte membrane portion 54 is held between a pair of gaskets 61 and 62, however, the structure may be made such that the electrolyte membrane 55 itself, that is, the ion exchange membrane

55 itself is held between a pair of gaskets 61 and 62, and this embodiment is shown as a fifth embodiment in Figs. 9 and 10.

That is, a gasket for a fuel battery shown in Figs. 9 and 10 is structured as follows.

That is, at first, the ion exchange membrane 55 corresponding to the electrolyte membrane 55 in the third and fourth embodiments is arranged between a pair of electrodes (also referred as outer electrodes) 52 and 53, and electrodes (also referred as inner electrodes) 59 and 60 are respectively arranged between the respective electrodes 52 and 53 and the ion exchange membrane 55, whereby a fuel battery cell 51 constituted by a five-layer laminated body made by arranging the electrode 52, the electrode 59, the ion exchange membrane 55, the electrode 60 and the electrode 53 in this order is formed.

A pair of electrodes 52 and 53 respectively correspond to the collector electrodes (the separators) mentioned above, are formed by the carbon plate, with a thickness of about 1 to 2 mm at actual size.

Further, the electrodes 59 and 60 respectively correspond to the membrane fixing reaction electrodes mentioned above, and are formed by the carbon so as to form a gas flow passage. A thickness of a three-layer

laminated body constituted by a pair of electrodes 59 and 60 and the ion exchange membrane 55 is about 0.5 to 1.5 mm at actual size.

Gaskets (also referred as gasket lips or seal members) 61 and 62 made of a low viscosity material are integrally formed on opposing surfaces to each other of a pair of electrodes 52 and 53 so as to correspond to each other, and the ion exchange membrane 55 is held between a pair of gaskets 61 and 62 in an unbonded manner, whereby the seal portion is formed.

As shown in Fig. 10 in an enlarged manner, one gasket 62 in an upper side in the drawing among a pair of gaskets 61 and 62 is formed with a flat surface portion (also referred as a flat portion) 62b at a front end portion thereof, and the plate surface portion 62b is provided with a predetermined width w_{11} . Further, another gasket 61 in a lower side in the drawing is formed with a front end portion 61b in a circular arc cross sectional shape, and is formed so that a width w_{12} of the front end portion 61b is smaller than the width w_{11} of the flat surface portion 62b in one gasket 62. One gasket 62 integrally has a rectangular cross sectional base portion 62c charged into a groove portion 53a, an extended portion 62e thereof and a trapezoidal cross sectional seal portion 62d integrally formed on a flat

surface of the base portion 62c, and the flat surface portion 62b is formed in the seal portion 62d. A width w13 of the base portion 62c and the extended portion 62e, that is, a whole width w13 of the gasket 62 is substantially 3 to 6 mm at actual size, a width w14 of the base portion is substantially 2 to 5 mm at actual size, a width w15 of the extended portion 62e is substantially 1 mm at actual size, a width w11 of the flat surface portion 62b is substantially 1 to 4 mm at actual size, a height h11 of the base portion 62c, that is, a height h11 of the extended portion 62e is substantially 0.2 to 0.5 mm at actual size, and a height h12 of the seal portion 62d is substantially 0.1 to 0.5 mm at actual size, respectively. Another gasket 61 integrally has a rectangular cross sectional base portion 61c charged into a groove portion 52a, an extended portion 61e thereof and a chevron cross sectional seal portion 61d integrally formed on a flat surface of the base portion 61c, and the circular arc cross sectional front end portion 61b is formed in the seal portion 61d. A width w16 of the base portion 61c and the extended portion 61e, that is, a whole width w16 of the gasket 61 is substantially 3 to 6 mm at actual size, a width w17 of the extended portion 61e is substantially 1 mm at actual size, a height h13 of the

base portion 61c, that is, a height h13 of the extended portion 61e is substantially 0.2 to 0.5 mm at actual size, a height h14 of the seal portion 61d is substantially 0.3 to 1.2 mm at actual size, and a radius of the circular arc of the front end portion 61b is substantially 0.1 to 0.5 mm at actual size, respectively. Both of the extended portions 61e and 62e are provided for the purpose of securing a gate port, and the extended portions 61e and 62e and expanded portions of the groove portions 52a and 53a for charging them are provided all around the periphery for reasons of a working cost, however, the structure may be of course made such that the groove portions 52a and 53a are expanded only at portions corresponding to the gate portions among all the periphery. Further, both of the gaskets 61 and 62 are respectively formed by the silicon rubber having a low hardness..

Since the gasket provided with the structure mentioned above is structured such that the gaskets 61 and 62 made of the silicon rubber corresponding to the liquid rubber hardened material are integrally formed on the surfaces of a pair of electrodes 52 and 53 corresponding to the flat surface plate porous member, and the rubber is integrally formed with the plate at the same time of forming, it is possible to realize making

the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, reducing a burr leakage and the like.

Further, since the flat surface portion 62b is provided in one of a pair of gaskets 61 and 62, the flat surface portion 62b forms a receiving side among a pair of seal portions by a pair of gaskets 61 and 62, and a area of the receiving side is set to be comparatively wide by the width w_{11} of the flat surface portion 62b. Accordingly, it is possible to enlarge an allowable range of the position shift from a medium value with respect to the closely contact position with the opposing member (the ion exchange membrane 55) of another gasket 62, whereby it is possible to

sufficiently secure a necessary sealing property even when the position shift is rather great. However, in view of the improvement of the seal property, since it is preferable that the contact surface pressure with respect to the opposing member (the ion exchange membrane 55) of the gasket 62 is as large as possible, it is preferable to restrict the width w11 of the flat surface portion 62b within a range required for solving the position shift problem mentioned above.

In this case, with respect to the gasket in accordance with the fifth embodiment, it is possible to add or modify the structure in the following manner.

① A pair of upper and lower gaskets 61 and 62 in Figs. 9 and 10 are respectively provided in the groove portions 52a and 53a formed on the surfaces of the electrodes 52 and 53. Instead of such structure, the gaskets 61 and 62 are directly provided on the surfaces of the electrodes 52 and 53, without having the groove portions 52a and 53a.

② The cross sectional shape of the seal portion of the gasket 62 provided with the flat surface portion 62b in the upper side in Figs. 9 and 10 is a trapezoidal shape or a substantially trapezoidal shape. Instead of such structure, the cross sectional shape is made

a quadrangular shape or a rectangular shape as shown in Fig. 11, and the gasket 62 is formed in a flat plate shape. In this case, the flat surface portion 62b is provided all along the width of the gasket 62.

③ The cross sectional shape of the seal portion of the gasket 61 in the lower side in Figs. 9 and 10 is a chevron shape. Instead of such structure, the cross sectional shape is made a trapezoidal shape or a substantially trapezoidal shape in the same manner as that of the upper side gasket 62 as shown in Fig. 12. Accordingly, in this case, the cross sectional shapes of both of the upper and lower gaskets 61 and 62 are respectively formed in the trapezoidal shape or substantially trapezoidal shape, and the flat surface portions 61a and 61b are respectively provided in both of the gaskets 61 and 62. Here, in this case, another gasket 61 integrally has a rectangular cross sectional base portion 61c charged into the groove portion 52a, an extended portion 61e thereof, and a trapezoidal cross sectional seal portion 61d integrally formed on a flat surface of the base portion 61c, and a flat surface portion 61b is formed in the seal portion 61d. A width w18 of the base portion 61c is substantially 2 to 5 mm at actual size, a width w19 of the flat surface portion 61a is substantially 1 to 4 mm at actual size, and a

height h15 of the seal portion 61d is substantially 0.1 to 0.5 mm at actual size, respectively. The cross sectional shape may be a quadrangular shape or a rectangular shape.

Further, the contents of modification on the basis of the items②and ③can be applied to the third and fourth embodiments mentioned above in which the electrolyte membrane portion 54 is held between a pair of gaskets 61 and 62, as it is.

Sixth embodiment

That is, at first, as shown in Fig. 13, a projection 72 is integrally formed on a surface of a flat surface plate 71 corresponding to a collector electrode (a separator), an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, along a gasket line (also referred as a gasket lip line), as shown in Fig. 13, and a gasket 73 made of a liquid rubber hardened material having a hardness (JIS A) 60 or less, preferably 5 to 50, and more preferably 10 to 40 is integrally formed so as to cover the projection 72 without using an adhesive agent or with using the adhesive agent.

The projection 72 is formed in a substantially triangular cross sectional shape or a substantially trapezoidal cross sectional shape, and is provided all along the length of the gasket line. The gasket 73 has a substantially triangular cross sectional or substantially circular arc cross sectional chevron portion 73a which covers the projection 72 and is in contact with an opposing member 74 at a time of assembling so as to achieve a seal operation, and flat bottom portions 73b having a lower height than that of the chevron portion 73a are integrally formed in both sides of the chevron portion 73a, respectively. Further, sizes of the respective portions are set on the basis of the following standards.

Width (maximum width in bottom line portion) w31 of the projection 72: 2 mm or less

Total width w32 of the gasket 73: 2 to 5 mm

Width w33 of the chevron portion 73a of the gasket 73: 1 to 5 mm

Height h31 of the bottom portion 73b of the gasket 73: 1 mm or less

Height h32 from the upper surface of the bottom portion 73b to the top point of the chevron portion 73a: 1 mm or less

Thickness t31 of the chevron portion 73a (minimum

width in a center in a width direction of the chevron portion): 1 mm or less

Width w34 of the recess portion 75 formed in the opposing member 74 with which the gasket is brought into contact at a time of assembling: a size equal to or more than the total width w32 of the gasket

Depth d31 of the recess portion 75: 1 mm or less

Further, the size of the respective portions are set as specific value under calculating so that an interval in a vertical direction between the projection 72 and the opposing member 74 at a time of assembling becomes between 0.2 and 1.0 mm and the gasket 73 having the thickness of 1.0 mm or less fills the gap on the basis of the interval so as to be compressed and serve a seal operation.

In the gasket provided with the structure mentioned above, since the gasket 73 made of a liquid rubber hardened material having a hardness (JIS A) 60 or less is integrally formed on a surface of a flat surface plate 71 corresponding to a collector electrode (a separator), an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, without using an

adhesive agent or with using the adhesive agent, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform, which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, reducing a burr leakage and the like.

Further, the projection 72 is integrally formed on the surface of the flat surface plate 71 corresponding to a collector electrode (a separator), an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, along a gasket line, and the gasket 73 made of a liquid rubber hardened material having a

hardness (JIS A) 60 or less is integrally formed so as to cover the projection 72 without using an adhesive agent or with using the adhesive agent, the projection 72 supports the gasket 73, thereby further effectively preventing the position shift of the gasket 73. Further, an amount of compression of the gasket 73 is limited, whereby it is possible to sufficiently secure a seal surface pressure with a low strain amount, and the projection 72 is provided instead of having the groove portion for preventing the lateral shift, whereby it is possible to improve a durability of the gasket. Further, in the case that the structure is made such as to support the gasket 73 only by the support of the projection without using the adhesive agent, it is possible to use the gasket with a safe conscience without taking into consideration a bad influence to the power generating efficiency by the use of the adhesive agent.

In this case, with respect to the gasket in accordance with the sixth embodiment, it is possible to add or modify the structure in the following manner.

That is, in the gasket in accordance with the embodiment mentioned above, the recess portion 75 is formed in the opposing member 74 with which the gasket 73 is brought into contact at a time of assembling, because the interval equal to or more than 0.2 mm is

set between the projection 72 and the opposing member 74 so as to restrict the amount of compression of the gasket 73 at a time when the surfaces 71a and 74a of the opposing member 74 and the flat surface plate 71 are in contact with each other so as to be positioned with each other. Accordingly, in place that the recess portion 75 is provided in the opposing member 74 as the means for restricting the amount of compression, the structure may be made such that a protruding or step-like spacer portion 76 is provided in the opposing member 74 as shown in Fig. 14, and a surface 76a of the spacer portion 76 is in contact with the surface 71a of the flat surface plate 71. Further, as shown in Fig. 15, the recess portion 75 may be provided in a side of the flat surface plate 71, or as shown in Fig. 16, the protruding or step-like spacer portion 76 may be provided in a side of the flat surface plate 71.

Seventh embodiment

Next, Fig. 17 shows a cross section of a gasket for a fuel battery in accordance with a seventh embodiment of the present invention, and the gasket is structured as follows.

That is, at first, a projection 72 is integrally formed on a surface of a flat surface plate 71 corresponding to a collector electrode (a separator),

an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, along a gasket line (also referred as a gasket lip line), and a gasket 73 made of a liquid rubber hardened material having a hardness (JIS A) 60 or less is integrally formed so as to cover the projection 72 without using an adhesive agent or with using the adhesive agent.

The projection 72 is formed in a substantially triangular cross sectional shape or a substantially trapezoidal cross sectional shape, and is provided all along the length of the gasket line. The gasket 73 is formed in a substantially triangular cross sectional shape or a substantially circular arc cross sectional shape in such a manner as to cover the projection 72 and be in contact with an opposing member 74 at a time of assembling so as to achieve a seal operation, and the bottom portions 73b in the sixth embodiment mentioned above is not provided. Further, sizes of the respective portions are set on the basis of the following standards.

Width (maximum width in bottom line portion) w31
of the projection 72: 2 mm or less

Total width w32 of the gasket 73: 2 to 5 mm

Total height h33 of the gasket 73: 2 mm or less

Thickness t31 of the gasket 73 (minimum width in a center in a width direction of the chevron portion):

1 mm or less

Width w34 of the recess portion 75 formed in the opposing member 74 with which the gasket is brought into contact at a time of assembling: a size equal to or more than the total width w32 of the gasket

Depth d31 of the recess portion 75: 1 mm or less

Further, the size of the respective portions are set as specific value under calculating so that an interval in a vertical direction between the projection 72 and the opposing member 74 at a time of assembling becomes between 0.2 and 1.0 mm and the gasket 73 having the thickness of 1.0 mm or less fills the gap on the basis of the interval so as to be compressed and serve a seal operation.

In the gasket provided with the structure mentioned above, since the gasket 73 made of a liquid rubber hardened material having a hardness (JIS A) 60 or less is integrally formed on a surface of a flat surface plate 71 corresponding to a collector electrode (a separator), an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a

conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, without using an adhesive agent or with using the adhesive agent, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform, which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, reducing a burr leakage and the like.

Further, the projection 72 is integrally formed on the surface of the flat surface plate 71 corresponding to a collector electrode (a separator), an ion exchange membrane, a membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange

resin, or a metal such as a stainless steel, a magnesium alloy or the like, along a gasket line, and the gasket 73 made of a liquid rubber hardened material having a hardness (JIS A) 60 or less is integrally formed so as to cover the projection 72 without using an adhesive agent or with using the adhesive agent, the projection 72 supports the gasket 73, thereby further effectively preventing the position shift of the gasket 73. Further, an amount of compression of the gasket 73 is limited, whereby it is possible to sufficiently secure a seal surface pressure with a low strain amount, and the projection 72 is provided instead of having the groove portion for preventing the lateral shift, whereby it is possible to improve a durability of the gasket. Further, in the case that the structure is made such as to support the gasket 73 only by the support of the projection without using the adhesive agent, it is possible to use the gasket with a safe conscience without taking into consideration a bad influence to the power generating efficiency by the use of the adhesive agent. Further, since the bottom portion is not provided in the gasket 73 and the gasket 73 is formed only in the substantially triangular cross sectional chevron portion or the substantially circular arc cross sectional chevron portion, it is possible to improve

a yield ratio of the molding material and it is possible to reduce a mounting space.

In this case, with respect to the gasket in accordance with the seventh embodiment, it is possible to add or modify the structure in the following manner.

That is, in the gasket in accordance with the embodiment mentioned above, the recess portion 75 is formed in the opposing member 74 with which the gasket 73 is brought into contact at a time of assembling, because the interval equal to or more than 0.2 mm is set between the projection 72 and the opposing member 74 so as to restrict the amount of compression of the gasket 73 at a time when the surfaces 71a and 74a of the opposing member 74 and the flat surface plate 71 are in contact with each other so as to be positioned with each other. Accordingly, in place that the recess portion 75 is provided in the opposing member 74 as the means for restricting the amount of compression, the structure may be made such that a protruding or step-like spacer portion 76 is provided in the opposing member 74 as shown in Fig. 18, and a surface 76a of the spacer portion 76 is in contact with the surface 71a of the flat surface plate 71. Further, as shown in Fig. 19, the recess portion 75 may be provided in a side of the flat surface plate 71, or as shown in Fig. 20, the

protruding or step-like spacer portion 76 may be provided in a side of the flat surface plate 71.

Eighth embodiment

Further, in connection with the technique that the rubbers are mounted on both surfaces of the plate via the through hole provided in the plate described in the second embodiment (Figs. 4 and 5), the applicant of the present invention further provides the following technique.

This technique relates to the sixteenth aspect and the seventeenth aspect of the present invention, and its main technical object is to provide a method of manufacturing a both surface lip gasket in which a crack and a permanent deformation of a substrate due to a molding pressure are hard to be generated at a time of molding seal lips on both surfaces, even in the case that the substrate is made of a brittle material or a material having a low strength, a low extension and a low elasticity. As a means for effectively achieving the technical object, in the method of manufacturing the both surface lip gasket in which the seal lips made of an elastomer are integrally formed on both surfaces of the substrate, a communication hole communicating between seal lip forming cavities formed between metal molds engaged and aligned with both surfaces is provided

in the substrate, the communication hole is disposed at a position corresponding to a gate open to one of both seal lip forming cavities and formed so as to have a larger diameter than that of the gate, and a molding material supplied from the gate is injected to the both seal lip forming cavities via the communication hole.

Further, in accordance with this method, the molding material supplied from the gate is injected into the seal lip forming cavities in both sides via the communication hole provided in the substrate at the position immediately under the gate. At this time, since the communication hole has a larger diameter than an opening diameter of the gate, a molding pressure does not start up first in the forming cavity in the side to which the gate is open, whereby it is possible to effectively prevent a pressure difference from being generated between both of the cavities. One or more gates are provided depend on the shape of the gasket.

As the substrate of the both surface lip gasket, in addition to the brittle material such as a molding carbon, for example, there can be listed up a porous material of a plastic, a ceramic or a metal corresponding to a low strength material, a thermosetting material such as a ceramic, a phenol resin or the like and a thermoplastic engineering plastic corresponding to a

low extension material, and a thermoplastic elastomer corresponding to a low elasticity material.

This technique can be widely applied to a forming technique of both surface lip gasket integrally having lip gaskets made of an elastomer on both surfaces of a thin substrate, such as a gasket for a circuit substrate, a gasket for a hard disc, a gasket for a fuel battery cell, and the like.

A description will be given below of a preferable embodiment of this method with reference to the accompanying drawings.

At first, both surface lip gasket shown in Fig. 21 is structured such that seal lips 82 and 83 made of an elastomer material, for example, a silicon rubber or the like are integrally formed on both surfaces of a bipolar plate 81 for a fuel battery in accordance with the method of the present invention.

In particular, the bipolar plate 81 is molded in a plate shape with a molding carbon of gas-proof compact bone, band-like grooves 81a and 81b are respectively formed in gasket attaching portions on both surfaces, and a communication hole 81c corresponding to a through hole passing through a portion between the groove bottoms is formed with a predetermined interval in a longitudinal direction of the band-like grooves 81a and

81b. Further, base portions 82a and 83a of the seal lips 82 and 83 are formed so as to fill up the band-like grooves 81a and 81b, and are connected to each other via a portion extending within the communication hole 81c, and chevron-shaped or convex lip main bodies 82b and 83b in the respective seal lips 82 and 83 are formed at positions shifted to one side in a width direction of the band-like grooves 81a and 81b from the communication hole 81c.

The fuel battery, as is well known, has a structure in which unit cells made by respectively arranging electrode plates corresponding to a fuel pole and an air pole in both sides in a thickness direction of the electrolyte membrane (the ion exchange membrane) are laminated via the bipolar plate 81 at a multiplicity of layers. The bipolar plate 81 has a function that the chevron-like lip main bodies 82b and 83b of the seal lips 82 and 83 protruding from both surfaces of the bipolar plate 81 is brought into close contact with the electrolyte membrane side with a proper crushing margin so as to seal, thereby preventing an air (an oxygen) supplied to the air pole in another side from being mixed within a flow passage of a hydrogen gas supplied to the fuel pole, preventing the hydrogen gas from being mixed within the air flow passage, and preventing a power

generation efficiency from being reduced, in addition to a function serving as an electron conductive body for connecting the respective cells in series.

Fig. 22 schematically shows a method of manufacturing the both surface lip gasket provided with the structure mentioned above. In Fig. 22, reference numerals 84 and 85 denote parts of an injection molding metal mold for molding the seal lips 82 and 83 on both surfaces of the bipolar plate 81. The bipolar plate 81 is held within a recess portion formed in the lower metal mold 85 in the drawing, and the structure is made such that both surfaces of the bipolar plate 81 are closely engaged and aligned with a lower surface (an aligned surface 84a) of the metal mold 84 and a recess portion bottom surface (an aligned surface 85a) of the metal mold 85 with a predetermined surface pressure, at a time of clamping the mold. In this case, the band-like grooves 81a and 81b and the communication hole 81c are previously formed in the bipolar plate 81.

Chevron grooves 84b and 85b opposing to the band-like grooves 81a and 81b formed in the bipolar plate 81 are respectively formed on the aligned surfaces 84a and 85a with the bipolar 81 in the metal molds 84 and 85. The chevron grooves 84b and 85b correspond to the chevron-like lip main bodies 82b and 83b shown in Fig.

21, have a smaller groove width than that of the band-like grooves 81a and 81b, and are formed at positions shifted to one side in a width direction of the band-like grooves 81a and 81b. Accordingly, in the illustrated mold clamping state, a seal lip forming cavity C1 is defined by the band-like groove 81a and the chevron groove 84b, and an opposite side seal lip forming cavity C2 is defined by the band-like groove 81b and the chevron groove 85b.

A gate 84c open toward the seal lip forming cavity C1 defined by clamping the mold is provided in one metal mold 84. The gate 84c constitutes a supply passage of the molding material from the molding material injection apparatus via a runner and a sprue (not shown) in the metal mold apparatus, and is open to the aligned surface 84a in correspondence to an open position of the communication hole 81c in a bottom portion of the band-like groove 81a of the bipolar plate 81. Further, an inner diameter $\phi 1$ of the communication hole 81c is about 1 mm at actual size, and the communication hole 1c is formed so as to have a larger diameter in comparison with an opening diameter $\phi 2$ of the gate 84c.

Prior to the mold clamping shown in Fig. 22, an evacuation is executed within the seal lip forming cavities C1 and C2 by a vacuum pump (not shown) or the

like. Further, when injecting the liquid-phase elastomer molding material supplied from the injection molding apparatus from the gate 84c after clamping the mold, the molding material is substantially simultaneously charged into the seal lip forming cavities C1 and C2 in both sides of the bipolar plate 81 via the communication hole 81c positioned immediately below the gate 84c.

At this time, since a relation $\phi 1 > \phi 2$ is established, a pressure reduction operation due to a fluid resistance in the communication hole 1c is not generated, so that a differential pressure is hardly generated between the seal lip forming cavities C1 and C2. Accordingly, it is possible to effectively prevent the crack due to the differential pressure between both of the cavities C1 and C2 from being generated in a thin portion between the band-like grooves 81a and 81b in the bipolar plate 81.

By using the molding carbon plate with a flexural strength 10MPa having a shape shown in Fig. 22 (thickness $T1 = 2$ mm, width of the band-like grooves 81a and 81b $W = 5$ mm, thickness between the band-like grooves 81a and 81b $T2 = 1$ mm), a test forming the seal lips on both surfaces is executed. In this test, while the opening

diameter $\phi 2$ of the gate 84c is set to 0.5 mm, the inner diameter $\phi 1$ of the communication hole 81c in the carbon plate in accordance with the embodiment is set to 1 mm which is larger than the diameter $\phi 2$, and the inner diameter $\phi 1$ of the communication hole 81c in the carbon plate in accordance with the comparative embodiment is set to 0.3 mm which is smaller than the diameter $\phi 2$. Table in Fig. 23 shows the test results. As a result of the test mentioned above, in the structure in accordance with the embodiment, it is recognized that no crack is generated in the molding carbon plate even under the standard molding pressure of 30 MPa and a normal injection molding can be executed.

In this case, in the embodiment mentioned above, the description is given only of the case that the both surface lip gasket is provided in the bipolar plate for the fuel battery, however, the present invention can be effectively applied to the case that the both surface lip gasket is formed on a circuit substrate made of a glass epoxy resin plate, a polyimide or a polyester resin sheet and a substrate made of a material having a low strength, a low extension and a low elasticity.

Further, in the illustrated embodiment, the base portions 82a and 83a of the seal lips 82 and 83 are formed

within the band-like grooves 81a and 81b, however, the present invention can be applied to a structure in which the band-like grooves 81a and 81b mentioned above are not formed.

Since the gasket described in each of the embodiments mentioned above is integrally formed on the substrate in spite that the width and the height thereof are significantly small, and even when the rubber hardness of the gasket is equal to or less than 60, preferably between 5 and 50, it is possible to accurately and quickly assemble the gasket, and it is possible to automate the assembling operation due to integral forming on the substrate, it is possible to reduce the size of the fuel battery due to the reduced height, it is possible to realize the low surface pressure due to the reduced hardness, and it is possible to absorb an unevenness even when the unevenness exists on the opposing surface of the gasket.

EFFECT OF THE INVENTION AND INDUSTRIAL APPLICABILITY

The present invention has the following effects.

That is, at first, in the gasket provided with the structure mentioned above in accordance with each of the aspects of the present invention, since each of the inventions is structured on the basis of the structure that the gasket lip made of the liquid rubber hardened

material is integrally formed on the surface of the flat surface plate or on the groove portion applied on the surface made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform, which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, improving a sealing property, reducing a molding process, reducing an adhesive treatment process, reducing a cost, reducing a burr leakage and the like.

Further, in addition thereto, in the gasket in accordance with the thirteenth aspect of the present invention provided with the structure mentioned above, since a pair of gasket lips are formed so as to have different cross sectional shapes and the flat surface portion is provided in one gasket lip, it is possible

to enlarge an allowable range of position shift from a medium value with respect to a closely contact position of another gasket lip with the opposing member, whereby it is possible to sufficiently secure a necessary sealing property even when the position shift is somewhat great.

Further, in the gasket in accordance with the fourteenth aspect or the fifteenth aspect of the present invention provided with the structure mentioned above, since the flat portion provided with the predetermined width being in contact with the electrolyte membrane portion or the ion exchange membrane is formed in at least one of a pair of gasket lips arranged so as to hold the electrolyte membrane portion or the ion exchange membrane between them, it is possible to enlarge the allowable range of position shift from the medium value with respect to the closely contact position of another gasket lip with the opposing member, whereby it is possible to sufficiently secure a necessary sealing property even when the position shift is somewhat great. Further, in the case that the flat surface portions are provided in both gasket lips, the contact state becomes stable, whereby it is possible to sufficiently secure the necessary sealing property.

Further, in the gasket in accordance with the

sixteenth aspect, the seventeenth aspect or the eighteenth aspect of the present invention provided with the structure mentioned above, since the projection is provided on the surface of the flat surface plate corresponding to the collector electrode (a separator), the ion exchange membrane, the membrane fixing reaction electrode or the like made of a carbon, a graphite, a conductive resin such as a conductive phenol or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like along the gasket lip line, the gasket lip is integrally formed so as to cover the projection and the projection supports the gasket lip, whereby it is possible to further effectively prevent the position shift of the gasket lip. Further, since an amount of compression of the gasket lip is restricted, it is possible to sufficiently secure the seal surface pressure with the low strain amount, and since the projection is provided instead of having the groove portion for preventing the lateral shift, it is possible to improve a durability of the gasket.

Further, in the forming method of the gasket in accordance with the nineteenth aspect or the twentieth aspect of the present invention provided with the structure mentioned above, it is possible to provide

the molding method which can stably mold the gasket, has a comparatively simple structure of the metal mold apparatus, and has a comparatively short cycle time.

Further, in the molding method of the gasket in accordance with the nineteenth aspect or the twentieth aspect of the present invention provided with the structure mentioned above, it is possible to realize making the seal portion thin, improving the assembling property, preventing the position shift, reducing the surface pressure and making the surface pressure uniform, which are conventionally problems, and further it is possible to realize reducing a number of the parts, preventing the position shift under a pressurizing condition during a use after assembling, stabilizing a size accuracy of the product, reducing an assembling problem, preventing an malfunction unstableness due to a mis-assembling, reducing a defective molding, stably molding the gasket, improving a sealing property, simplifying a metal mold structure, reducing a molding process, directly molding the gaskets on both surfaces of the thin plate, reducing an adhesive treatment process, reducing a cost, reducing a cycle time, preventing a plate crack, reducing a burr leakage and the like.

Further, in the gasket in accordance with the

twenty first aspect of the present invention provided with the structure mentioned above and the molding method of the gasket in accordance with the twenty second aspect of the present invention, since the communication hole having a larger diameter than that of the gate is provided in the substrate so as to communicate the cavities in both sides with each other, the molding material supplied from the gate is injected into the seal lip molding cavities in both sides via the communication hole, and at this time, the pressure difference due to the reason that the molding pressure first starts up in one molding cavity is restricted to be small, it is possible to prevent the crack and the permanent deformation of the substrate due to the pressure difference from being generated, and accordingly, it is possible to effectively apply to the case of forming the both surface lip gasket on the substrate made of the brittle material or the like, for example, the bipolar plate for the fuel battery or the like.

WHAT IS CLAIMED IS:

1. A gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed on a surface of a flat plate or a groove portion applied to said surface.

2. A gasket for a fuel battery as claimed in claim 1, characterized in that the flat plate is a collector electrode, an ion exchange membrane or a membrane fixing reaction electrode.

3. A gasket for a fuel battery as claimed in claim 1, characterized in that the liquid rubber hardened material has a hardness of (JIS A) 60 or less.

4. A gasket for a fuel battery as claimed in claim 3, characterized in that the hardness (JIS A) of the liquid rubber hardened material is preferably between 5 and 50 and more preferably between 10 and 40.

5. A gasket for a fuel battery as claimed in claim 1, characterized in that a viscosity ($\text{Pa} \cdot \text{s}$ (25 degrees Celsius)) of the liquid rubber is between 30 and 10,000 and preferably between 30 and 2,000.

6. A gasket for a fuel battery as claimed in claim 1, characterized in that a cross sectional shape of the gasket lip made of the liquid rubber hardened material is a trapezoidal shape or a chevron shape.

7. A gasket for a fuel battery as claimed in claim

1, characterized in that a cross sectional shape of the gasket made of the liquid rubber hardened material is provided with a portion having a trapezoidal cross section or a portion having a chevron cross section.

8. A gasket for a fuel battery as claimed in claim 1, characterized in that a seal portion of the gasket lip has a circular arc cross sectional shape.

9. A gasket for a fuel battery as claimed in claim 8, characterized in that the seal portion has a height of substantially 0.2 to 1.5 mm.

10. A gasket for a fuel battery as claimed in claim 1, characterized in that the seal portion of the gasket lip has a chevron cross sectional shape, a convex cross sectional shape or a triangular cross sectional shape.

11. A gasket for a fuel battery as claimed in claim 10, characterized in that the seal portion has a height of substantially 0.3 to 1.5 mm.

12. A gasket for a fuel battery as claimed in claim 10, characterized in that a front end portion of the seal portion has a circular arc cross sectional shape.

13. A gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on said surface, a pair of said gasket lips arranged so as to hold an electrolyte

membrane portion between them are formed so as to have different cross sectional shapes, and a flat surface portion provided with a predetermined width being in contact with said electrolyte membrane portion is formed in one of said gasket lips.

14. A gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on said surface, a flat surface portion provided with a predetermined width being in contact with an electrolyte membrane portion is formed in at least one of a pair of said gasket lips arranged so as to hold said electrolyte membrane portion between them.

15. A gasket for a fuel battery, characterized in that gasket lips made of a liquid rubber hardened material are integrally formed on a surface of an electrode or a groove portion applied on said surface, and a flat surface portion provided with a predetermined width being in contact with an ion exchange membrane is formed in at least one of a pair of gasket lips arranged so as to hold said ion exchange membrane between them.

16. A gasket for a fuel battery as claimed in claim 1, characterized in that a projection along a gasket lip line is provided on the flat surface plate, and the

gasket lip is formed so as to cover said projection.

17. A gasket for a fuel battery as claimed in claim 1, characterized in that a projection along a gasket lip line is provided on the flat surface plate, an adhesive agent is applied around said projection, and the gasket lip is formed so as to cover the area.

18. A gasket for a fuel battery as claimed in claim 1, characterized in that a projection along a gasket lip line is provided in the flat surface plate, an adhesive agent is not applied around said projection, and the gasket lip is formed so as to cover the area.

19. A method of forming a gasket for a fuel battery as claimed in any one of claims 1 to 18, characterized in that a gap is provided between upper and lower molds before injecting so as to evacuate, and thereafter the molds are clamped so as to injection mold the gasket lip.

20. A method of forming a gasket for a fuel battery as claimed in claim 19, characterized in that a through hole open to both surfaces of the flat plate or bottom surfaces of groove portions applied to said both surfaces is provided, and the gasket lip is integrally formed in said both surfaces or both groove portions through said through hole simultaneously.

21. A gasket for a fuel battery, characterized in that

a pair of groove portions are provided so as to respectively correspond to both surfaces of a substrate, a communication hole is provided in said substrate so as to communicate said pair of groove portions, an elastomer is charged into said pair of groove portions and the communication hole, a convex seal lip is provided in the elastomer, said communication hole is arranged at a position biasing to one side in a width direction of said groove portion, and said convex seal lip is arranged at a position biasing to the opposite side.

22. A method of forming a gasket for a fuel battery integrally provided with a seal lip constituted of an elastomer on both surfaces of a substrate, characterized in that a communication hole communicating between seal lip forming cavities which are formed between the substrate and metal molds engaged and aligned with both surfaces of the substrate is provided in said substrate, said communication hole is formed at a position corresponding to a gate open to one of said both seal lip forming cavities with a larger diameter than that of the gate, and a forming material supplied from said gate is charged into said both seal lip forming cavities via said communication hole.

ABSTRACT OF THE DISCLOSURE

In a gasket used for a fuel battery, in order to solve problems with respect to making a seal portion thin, improving an assembling property, preventing a position shift, making a surface pressure low, making the surface pressure uniform, and the like, a gasket lip made of a liquid rubber hardened material is integrally formed on a surface of a flat plate made of a carbon, a graphite, a conductive resin such as a conductive phenol resin or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, or on a groove portion applied to the surface.

23. (Added) A gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a carbon plate or a groove portion applied to said surface.

24. (Added) A gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a graphite plate or a groove portion applied to said surface.

Description on the basis of Treaty 19(1)

Newly added claim 23 relates to a gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a carbon plate or a groove portion applied to the surface, and is described in none of the references cited in the International Search Report with respect to the present case.

Further, newly added claim 24 relates to a gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a graphite plate or a groove portion applied to the surface, and is also described in none of the references cited in the International Search Report with respect to the present case.

Fig. 3

CLAMP MOLD AT LOW PRESSURE

IS MOLD CLAMPING TEMPORARILY STOPPING POSITION ?

S101 STOP MOLD CLAMPING

S102 MOVE FORWARD NOZZLE

IS NOZZLE TOUCH COMPLETED ?

S103 TURN ON VACUUM PUMP

IS SET VACUUM ?

IS SET EVACUATING TIME ?

S104 CLAMP MOLD AT HIGH PRESSURE

OPEN SHUT-OFF VALVE

S105 INJECT

Fig. 23

MOLDING PRESSURE

MOLD CLAMPING FORCE

MOLDING PRESSURE

MOLD CLAMPING FORCE

COMPARATIVE EMBODIMENT

CRACK GENERATION

GOOD

EMBODIMENT

GOOD

GOOD

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 (4) _____ and
 (5) _____

In consideration of the sum of one dollar (\$1.00), and other good and valuable considerations paid to each of the undersigned, the receipt and sufficiency of which are hereby acknowledged, the undersigned hereby assigns, transfers and sets over to

(6) Insert Name of Assignee (6) NOK CORPORATION

(7) Insert Address of Assignee (7) of 12-15, Shibadaimon 1-chome, Manato-ku, Tokyo 105-8585

(8) Insert Legal Entity and State or Country (e.g., a corporation or citizen of Japan) (8) a corporation of Japan Japan
 (hereinafter designated as the Assignee) the entire right, title and interest for the United States, its territories, dependencies and possessions, in the invention known as

(9) Insert Identification of Invention, such as Title, Case Number or Foreign Application Number (9) GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME

(10) Insert Date of signing of Application, or filing date and Serial No., if known (10) Said application having been executed/ filed on October 13, 2001 (and assigned Serial No. _____)

1) The undersigned agree(s) to execute all papers necessary in connection with this application and any continuing or divisional applications thereof and also to execute separate assignments in connection with such applications as the Assignee may deem necessary or expedient.

2) The undersigned agree(s) to execute all papers necessary in connection with any interference which may be declared concerning this application or any continuing or divisional applications thereof and to cooperate with the Assignee in every way possible in obtaining evidence and going forward with such interference.

3) The undersigned agree(s) to execute all papers and documents and perform any act which may be necessary in connection with claims or provisions of the International Union for Protection of Industrial Property or similar agreements.

4) The undersigned agree(s) to perform all affirmative acts which may be necessary to obtain a grant of a valid United States patent to the Assignee.

5) The undersigned hereby authorize(s) and request(s) the Commissioner of Patents and Trademarks to issue any and all Letters Patents of the United States resulting from this application or any continuing or divisional applications thereof to the said Assignee, as Assignee of the entire interest, and hereby covenants that he has (they have) full right to convey the entire interest herein assigned, and that he has (they have) not executed, and will not execute any agreement in conflict herewith.

6) Assignor hereby further assigns to Assignee all claims and causes of action for infringement of the patent rights assigned herein, including the right to sue for, and collect damages for, any and all acts of past and future infringement.

7) The undersigned hereby grant(s) the law firm of Jacobson, Price, Holman & Stern, PLLC, 400 Seventh Street, N.W., Washington, D.C. 20004, the power to insert on this assignment any further identification which may be necessary or desirable in order to comply with the rules of the United States Patent and Trademark Office for recordation of this document.

In witness whereof, executed by the undersigned on the date(s) opposite the undersigned name(s).

Date	<u>October 15, 2001</u>	Name of Inventor	NAGAI Osamu	<u>Osamu Nagai</u>	(SEAL)
			typed name	signature	
Date	<u>October 13, 2001</u>	Name of Inventor	WAKAMATSU Shigeo	<u>Shigeo Wakamatsu</u>	(SEAL)
			typed name	signature	
Date	<u>October 13, 2001</u>	Name of Inventor	KUROKI Yuichi	<u>Yuichi Kuroki</u>	(SEAL)
			typed name	signature	
Date	_____	Name of Inventor	_____	_____	(SEAL)
			typed name	signature	
Date	_____	Name of Inventor	_____	_____	(SEAL)
			typed name	signature	

This assignment should preferably be signed before a United States Consul if signed abroad, or a Notary Public if domestically signed. If not, then the execution by the inventor(s) should be witnessed by at least two witnesses who sign here:

☐ Additional inventor's names and signatures on a separate sheet.

Witness _____

Witness _____

LAW OFFICES OF
JACOBSON, PRICE, HOLMAN & STERN
 PROFESSIONAL LIMITED LIABILITY COMPANY
 THE JENIFER BUILDING
 400 SEVENTH STREET, N.W.
 WASHINGTON, D.C. 20004

DECLARATION AND POWER OF ATTORNEY U.S.A.

FOR ATTORNEYS' USE ONLY

ATTORNEYS' DOCKET NO.

182

ALL PATENTS, INCLUDING DESIGN
FOR APPLICATION BASED ON PCT; PARIS CONVENTION;
NON PRIORITY; OR PROVISIONAL APPLICATIONS

As a below named inventor, I declare that my residence, post office address and citizenship are stated below next to my name, the information given herein is true, that I believe that I am the original, first and sole inventor (if only one name is listed at 201 below), or an original, first and joint inventor (if plural inventors are named below at 201-203, or on additional sheets attached hereto) of the subject matter which is claimed and for which patent is sought on the invention entitled:

GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME

which is described and claimed in:

☒ PCT International Application No. PCT/JP00/03853

filed June 14, 2000

☐ the attached specification

☐ the specification in application Serial No. _____

filed _____

(if applicable) and amended on _____

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 (a)-(d) of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

Prior Foreign Application(s)

Priority Claimed

198413/1999

Japan

13/07/1999

☒

☐

(Number)

(Country)

(Day/Month/Year Filed)

Yes

No

293988/1999

Japan

15/10/1999

☒

☐

(Number)

(Country)

(Day/Month/Year Filed)

Yes

No

308424/1999

Japan

29/10/1999

☒

☐

(Number)

(Country)

(Day/Month/Year Filed)

Yes

No

I hereby claim the benefit under Title 35, United States Code, §119(e) of any United States provisional application(s) listed below:

Application No. _____

Filing Date _____

Application No. _____

Filing Date _____

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, §1.56 which became available between the filing date of the prior application and the national or PCT international filing date of this application:

(Application Serial No.)

(Filing Date)

(Status: patented, pending, abandoned)

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorneys (Registration No.) to prosecute this application, receive and act on instructions from my agent, and transact all business in the Patent and Trademark Office connected therewith. HARVEY B. JACOBSON, JR. (20,851); D. DOUGLAS PRICE (24,514); JOHN CLARKE HOLMAN (22,769); MARVIN R. STERN (20,640); ALLEN S. MELSER (27,215); MICHAEL R. SLOBASKY (26,421); JONATHAN L. SCHERER (29,851); IRWIN M. AISENBERG (19,007); WILLIAM E. PLAYER (31,409); YOON S. HAM (45,307) and NATHANIEL A. HUMPHRIES (22,772)

SEND CORRESPONDENCE TO: CUSTOMER NO. 00136

or

JACOBSON, PRICE, HOLMAN & STERN
PROFESSIONAL LIMITED LIABILITY COMPANY
400 SEVENTH STREET, N.W.
WASHINGTON, D.C. 20004

DIRECT TELEPHONE CALLS TO:

(please use Attorney's Docket No.) (202) 638-6666

JACOBSON, PRICE, HOLMAN & STERN
PROFESSIONAL LIMITED LIABILITY COMPANY

*Inventor(s) name must include at least one unabbreviated first or middle name.

201	FULL NAME * OF INVENTOR	FAMILY NAME <u>NAGAI</u>	GIVEN NAME <u>Osamu</u>	MIDDLE NAME
	RESIDENCE & CITIZENSHIP	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR FOREIGN COUNTRY <u>Japan</u>	COUNTRY OF CITIZENSHIP <u>Japan</u>
	POST OFFICE ADDRESS	POST OFFICE ADDRESS <u>c/o NOK CORPORATION, 4-3-1, Tsujido-shinmachi</u>	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR COUNTRY <u>Japan</u>
202	FULL NAME * OF INVENTOR	FAMILY NAME <u>WAKAMATSU</u>	GIVEN NAME <u>Shigeo</u>	MIDDLE NAME
	RESIDENCE & CITIZENSHIP	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR FOREIGN COUNTRY <u>Japan</u>	COUNTRY OF CITIZENSHIP <u>Japan</u>
	POST OFFICE ADDRESS	POST OFFICE ADDRESS <u>c/o NOK CORPORATION, 4-3-1, Tsujido-shinmachi</u>	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR COUNTRY <u>Japan</u>
203	FULL NAME * OF INVENTOR	FAMILY NAME <u>KUROKI</u>	GIVEN NAME <u>Yuichi</u>	MIDDLE NAME
	RESIDENCE & CITIZENSHIP	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR FOREIGN COUNTRY <u>Japan</u>	COUNTRY OF CITIZENSHIP <u>Japan</u>
	POST OFFICE ADDRESS	POST OFFICE ADDRESS <u>c/o NOK CORPORATION, 4-3-1, Tsujido-shinmachi</u>	CITY <u>Fujisawa-shi, Kanagawa</u>	STATE OR COUNTRY <u>Japan</u>

I further declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment or both, under section 1001 of Title 18 of the United States Code; and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

SIGNATURE OF INVENTOR 201*	SIGNATURE OF INVENTOR 202*	SIGNATURE OF INVENTOR 203*
<u>Osamu Nagai</u>	<u>Shigeo Wakamatsu</u>	<u>Yuichi Kuroki</u>
DATE <u>October 15, 2001</u>	DATE <u>October 13, 2001</u>	DATE <u>October 13, 2001</u>

☐ Additional inventors are named on separately numbered sheets attached hereto.

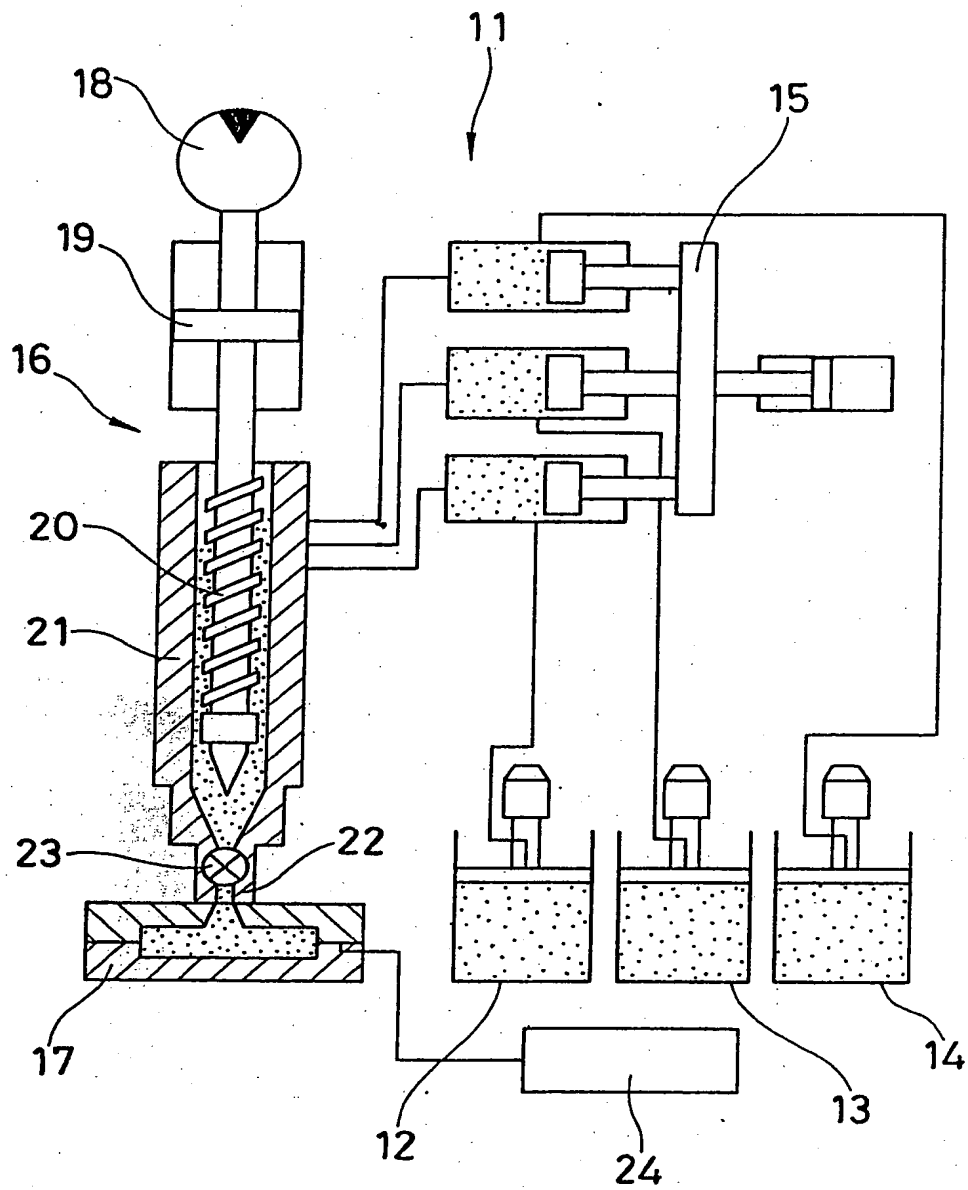
Prior Foreign Application(s)

Priority Claimed

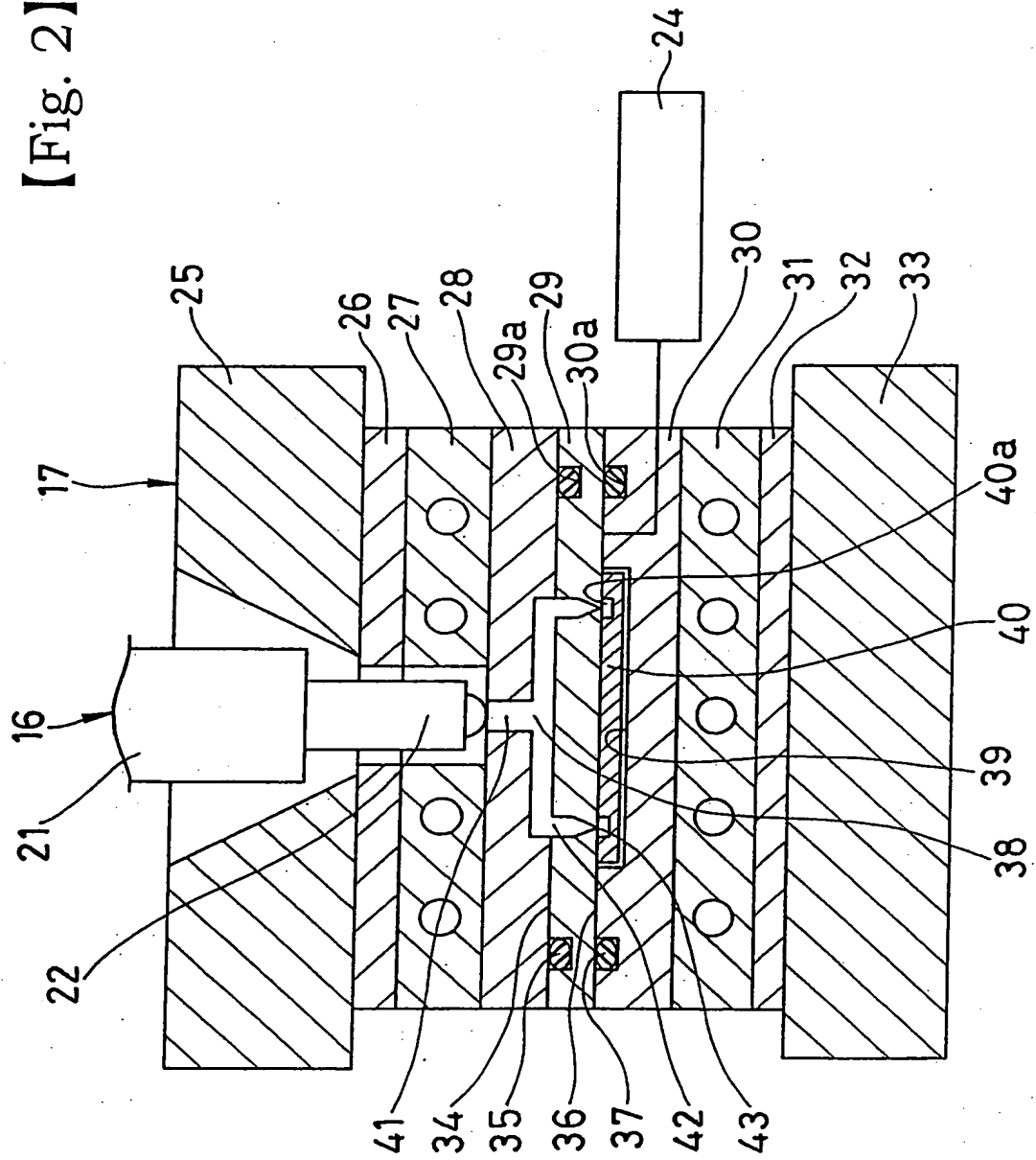
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(Number)	(Country)	(Day/Month/Year Filed)
<u> </u>	<u> </u>	<u> </u>
(Number)	(Country)	(Day/Month/Year Filed)
<u> </u>	<u> </u>	<u> </u>
(Number)	(Country)	(Day/Month/Year Filed)

<input checked="" type="checkbox"/>	<input type="checkbox"/>
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Yes	No
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Yes	No

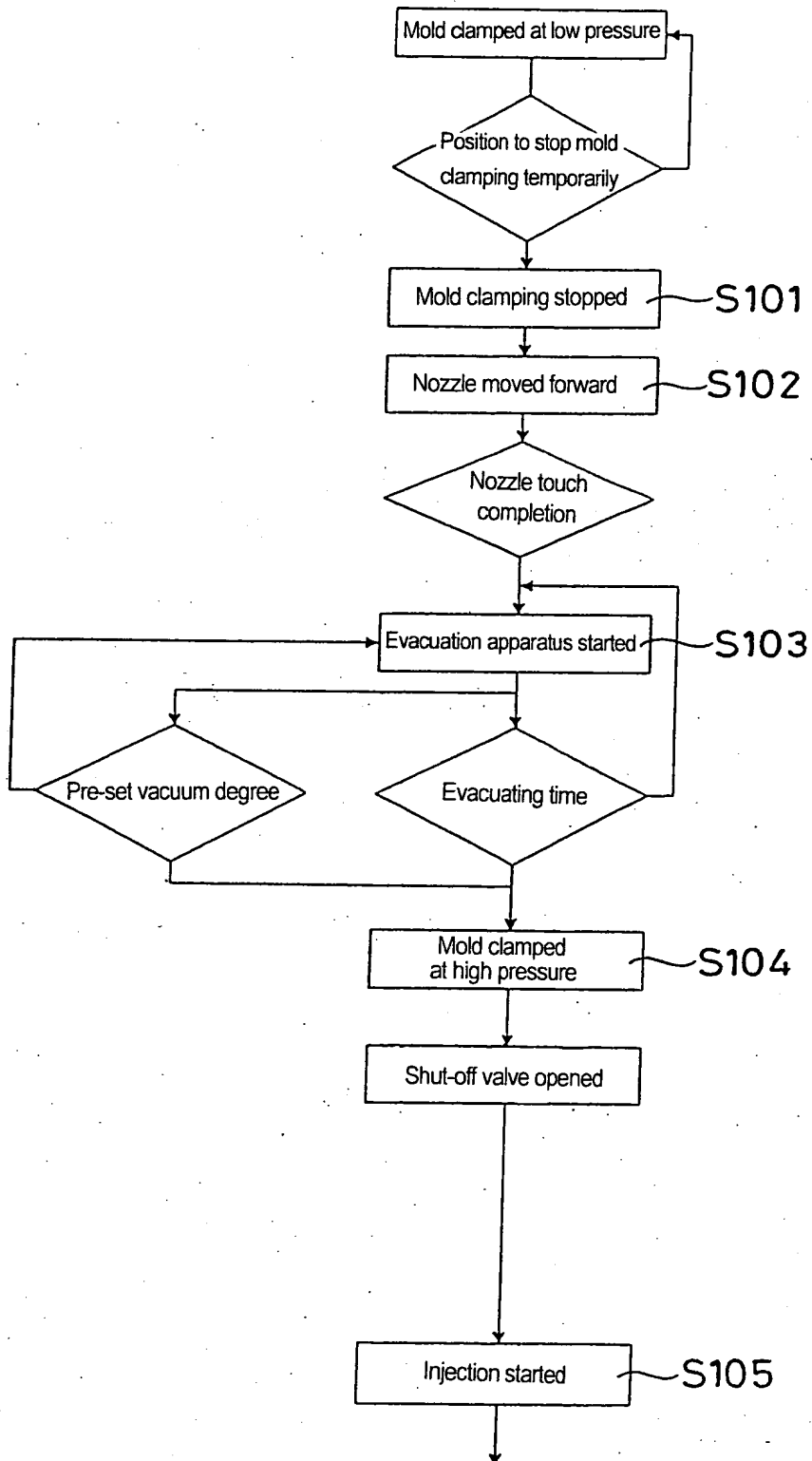
【Fig. 1】



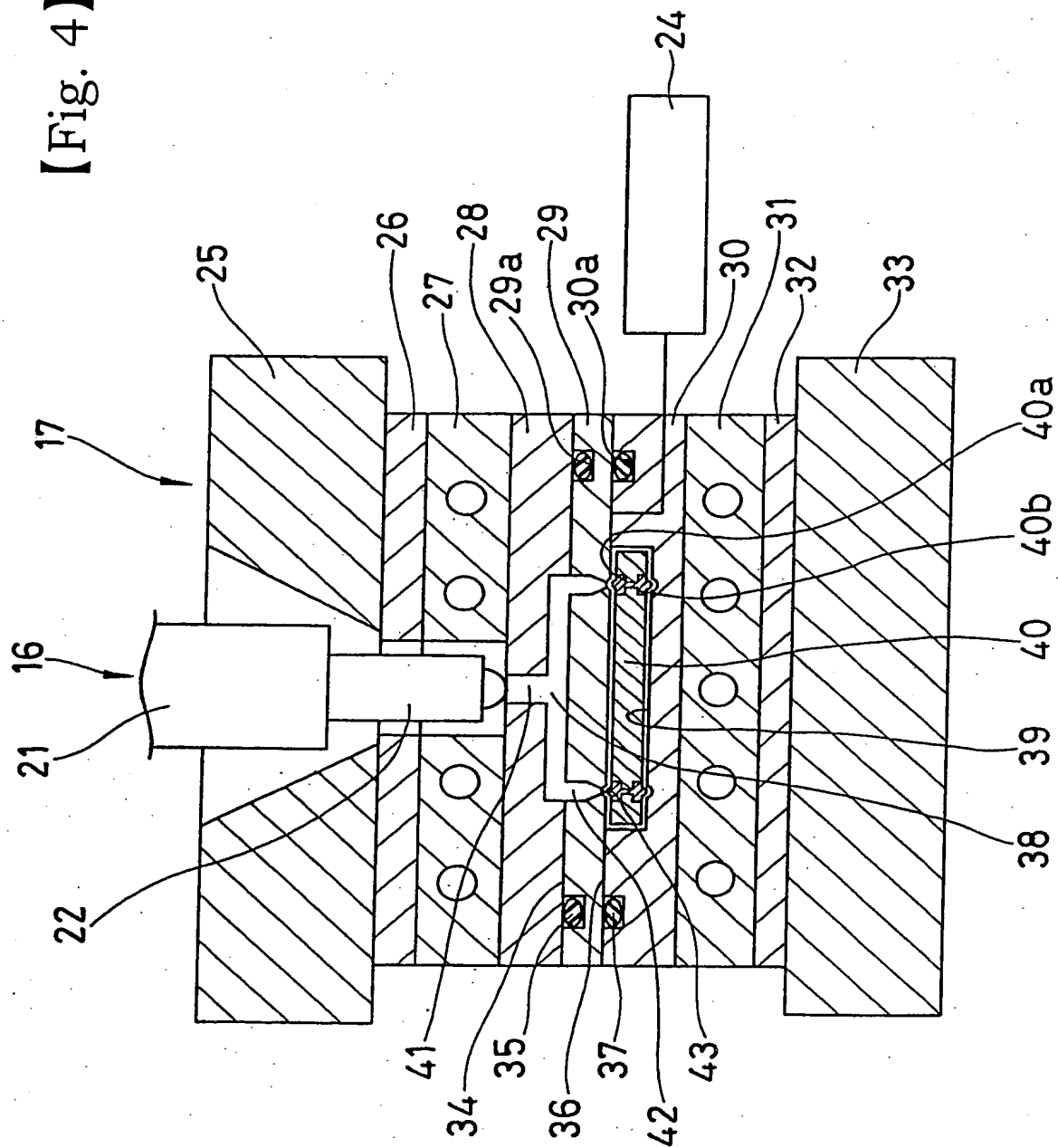
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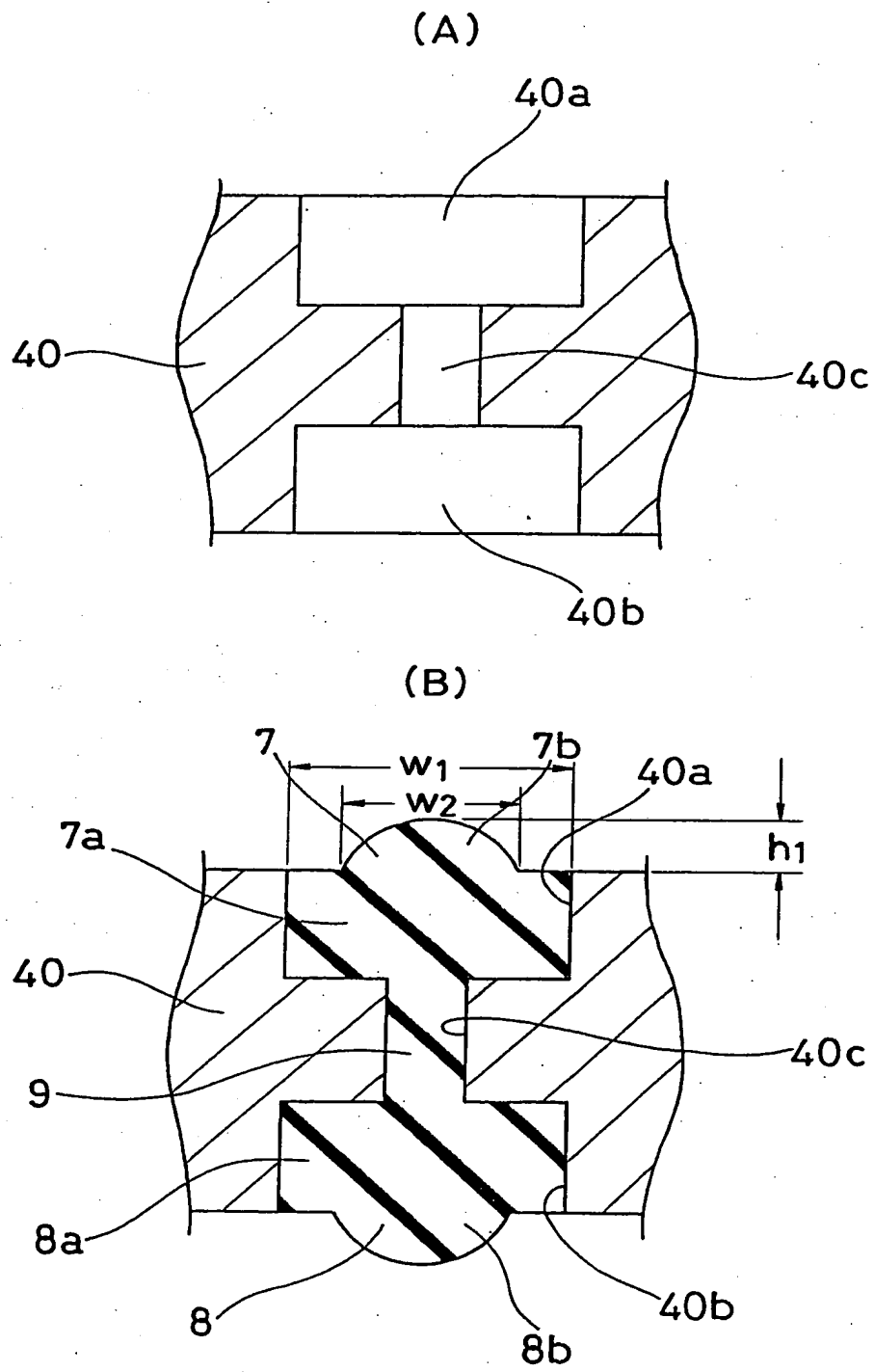
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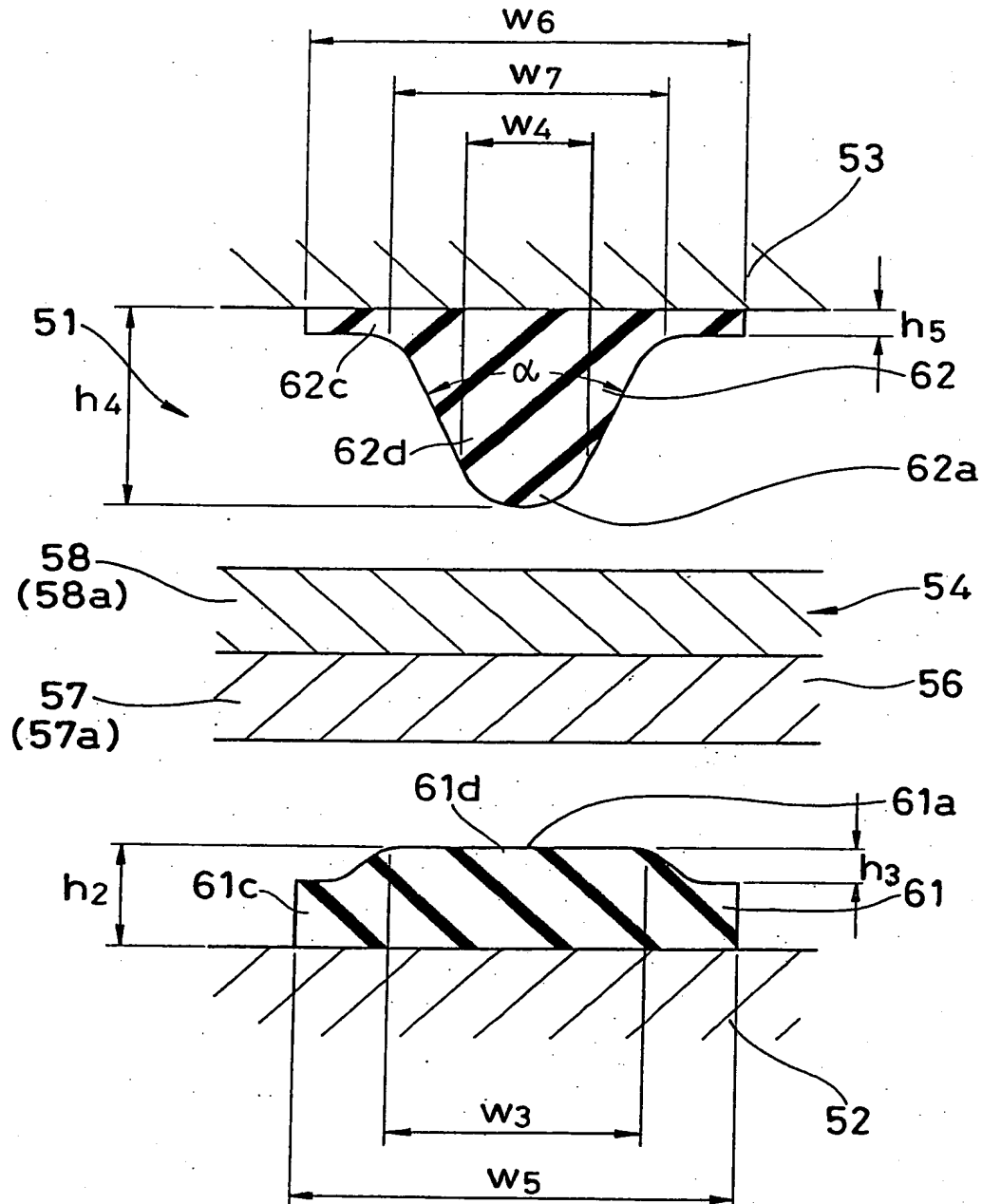
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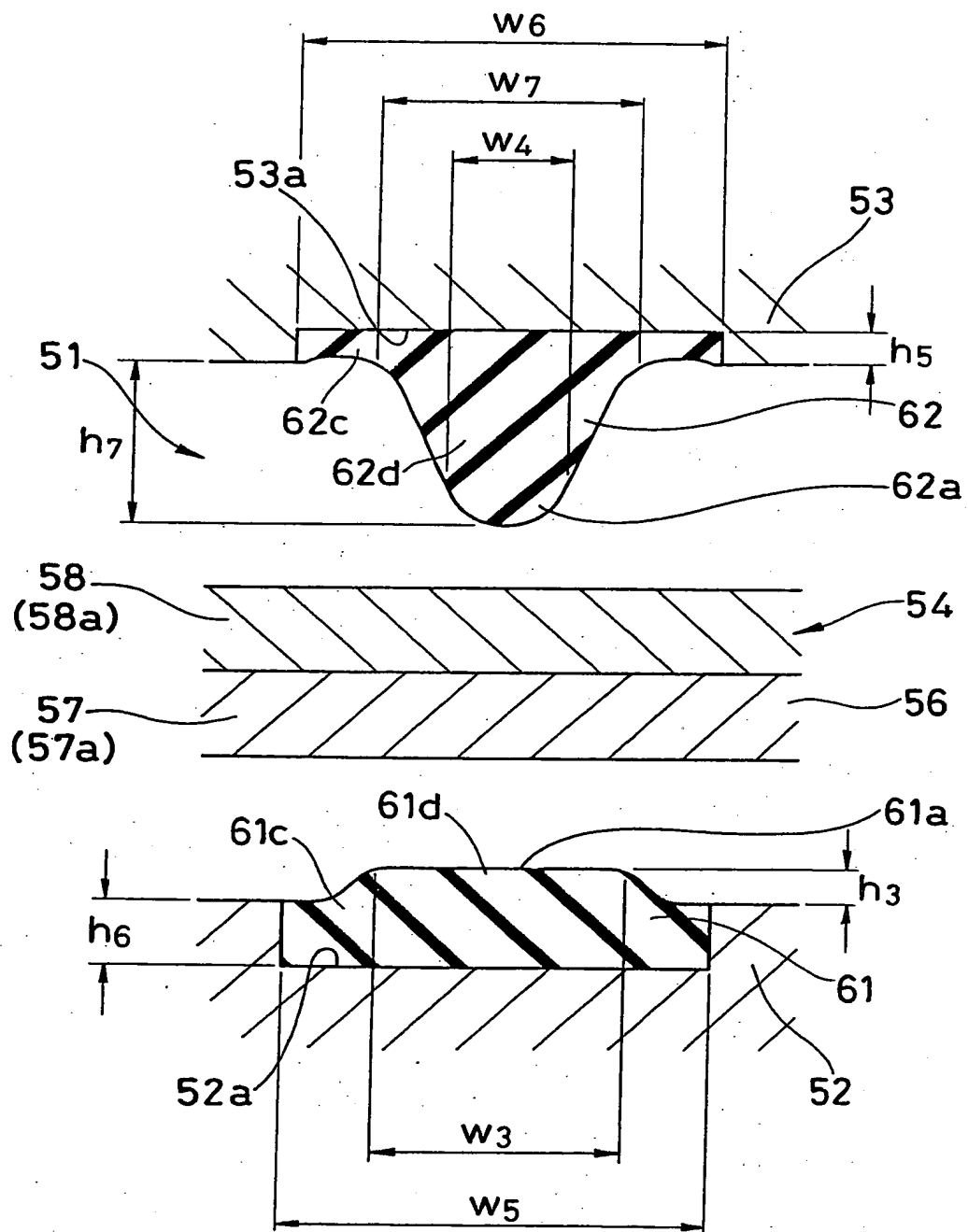
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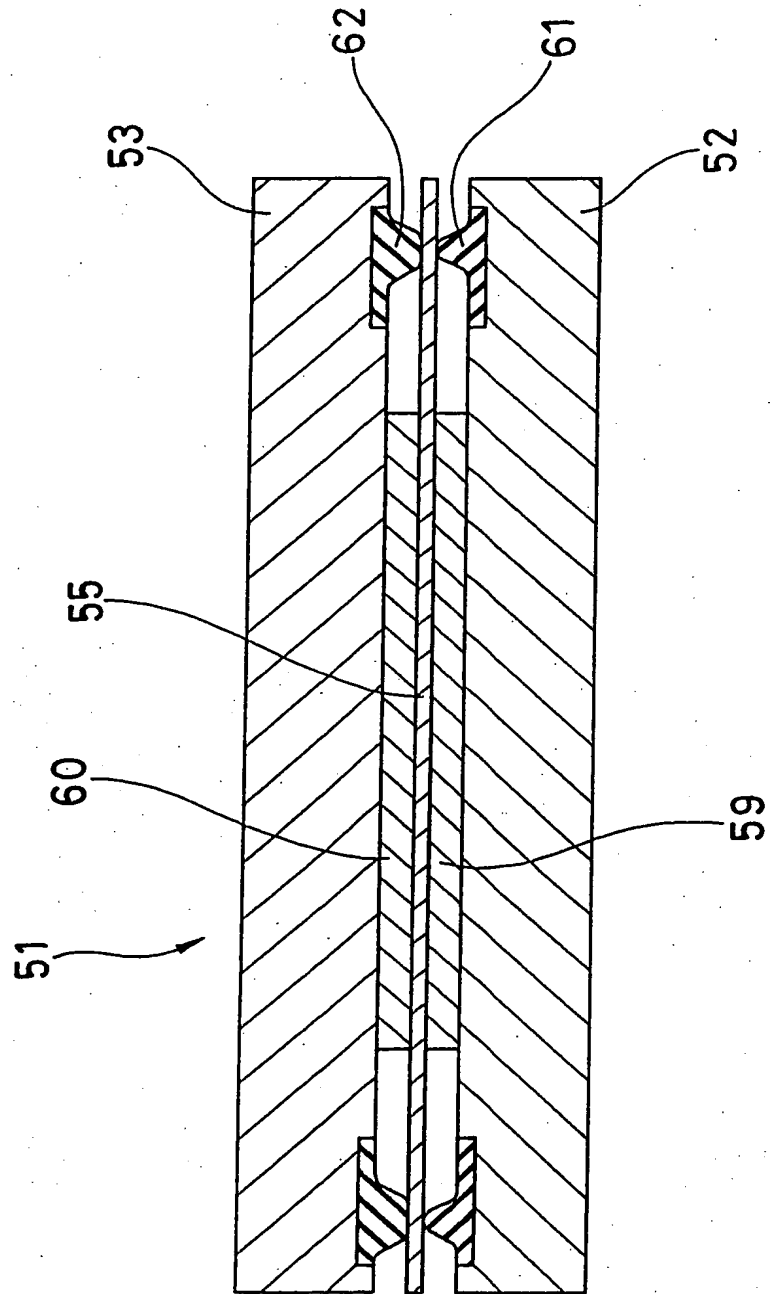
【Fig. 7】



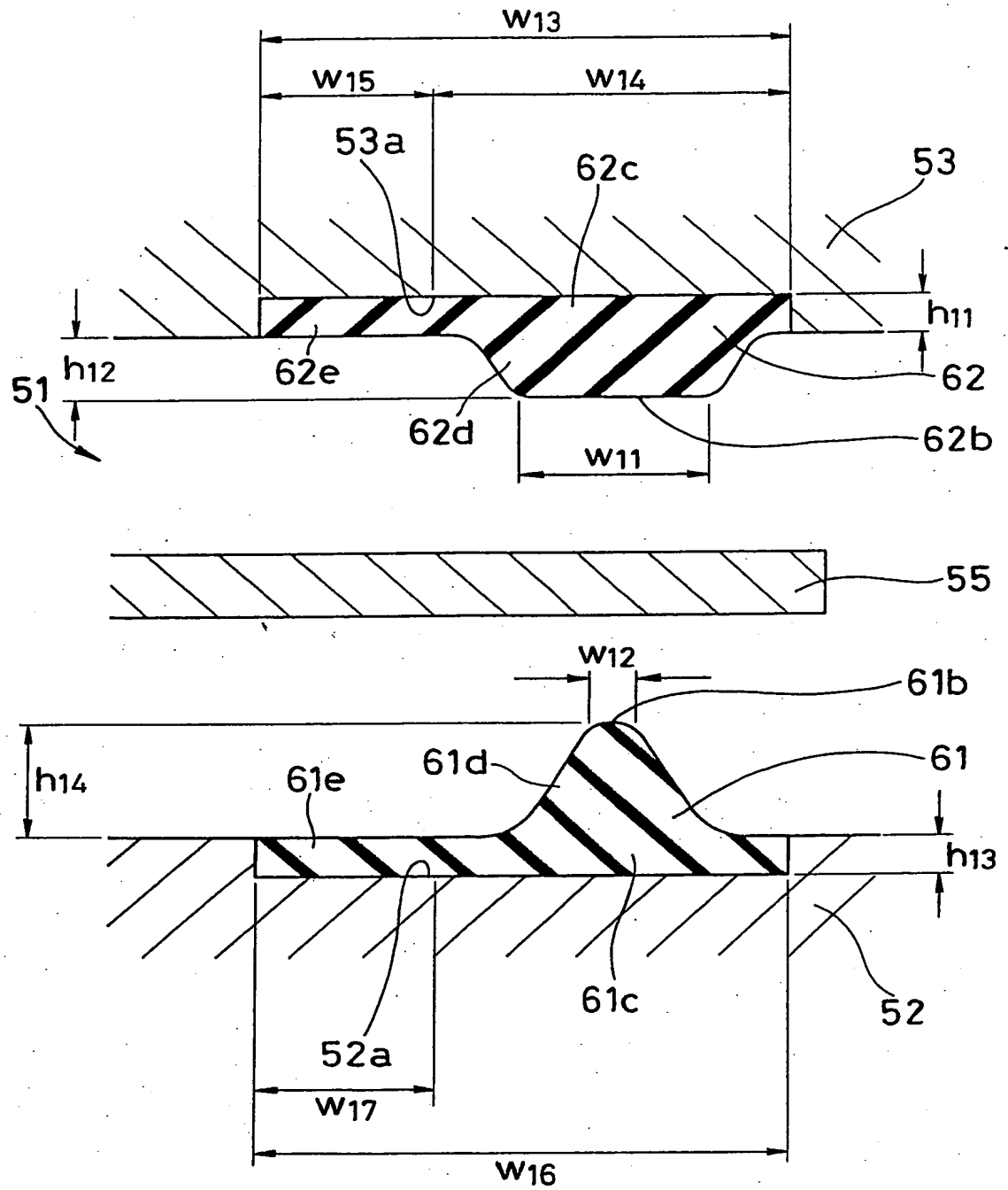
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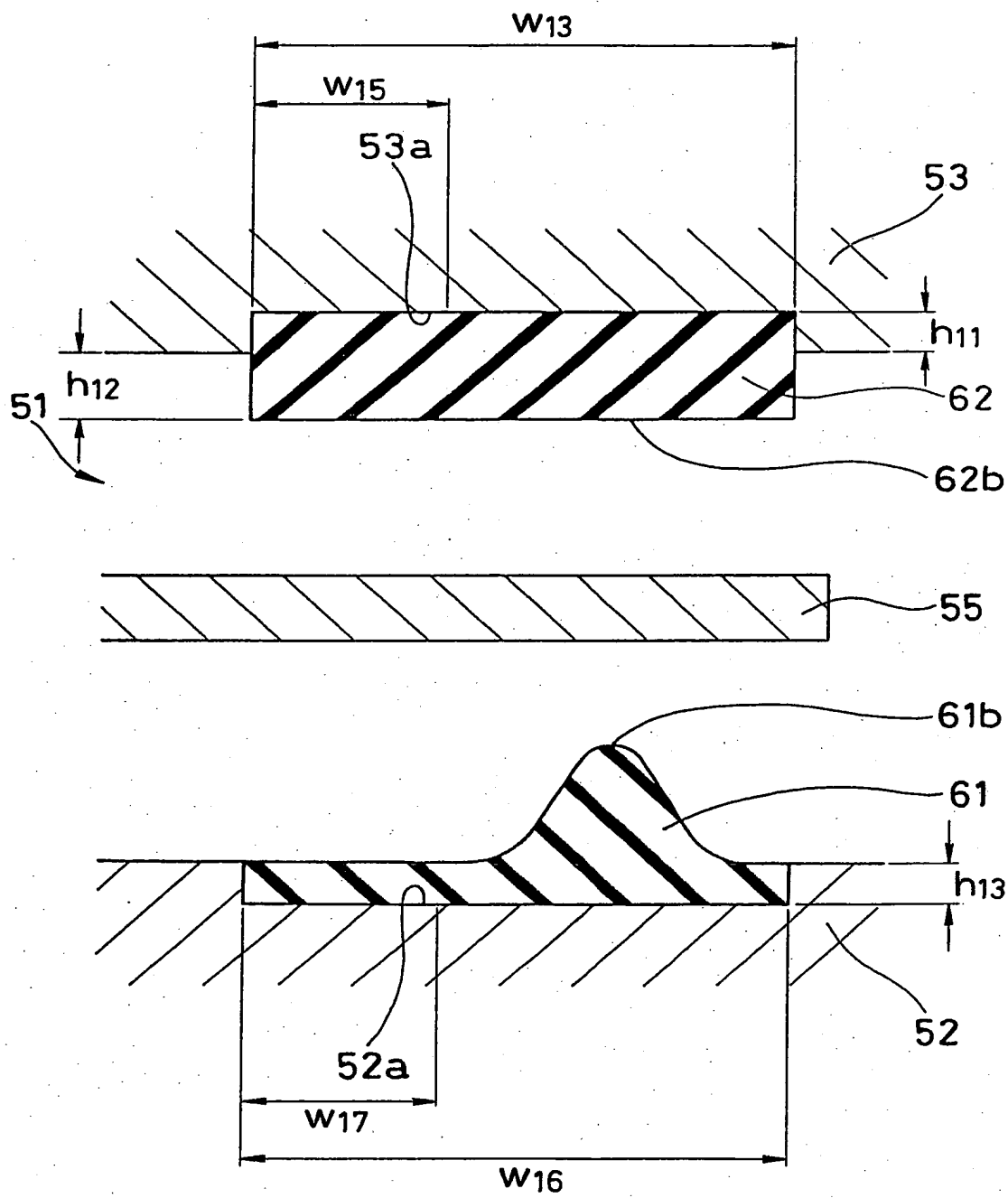
【Fig. 9】



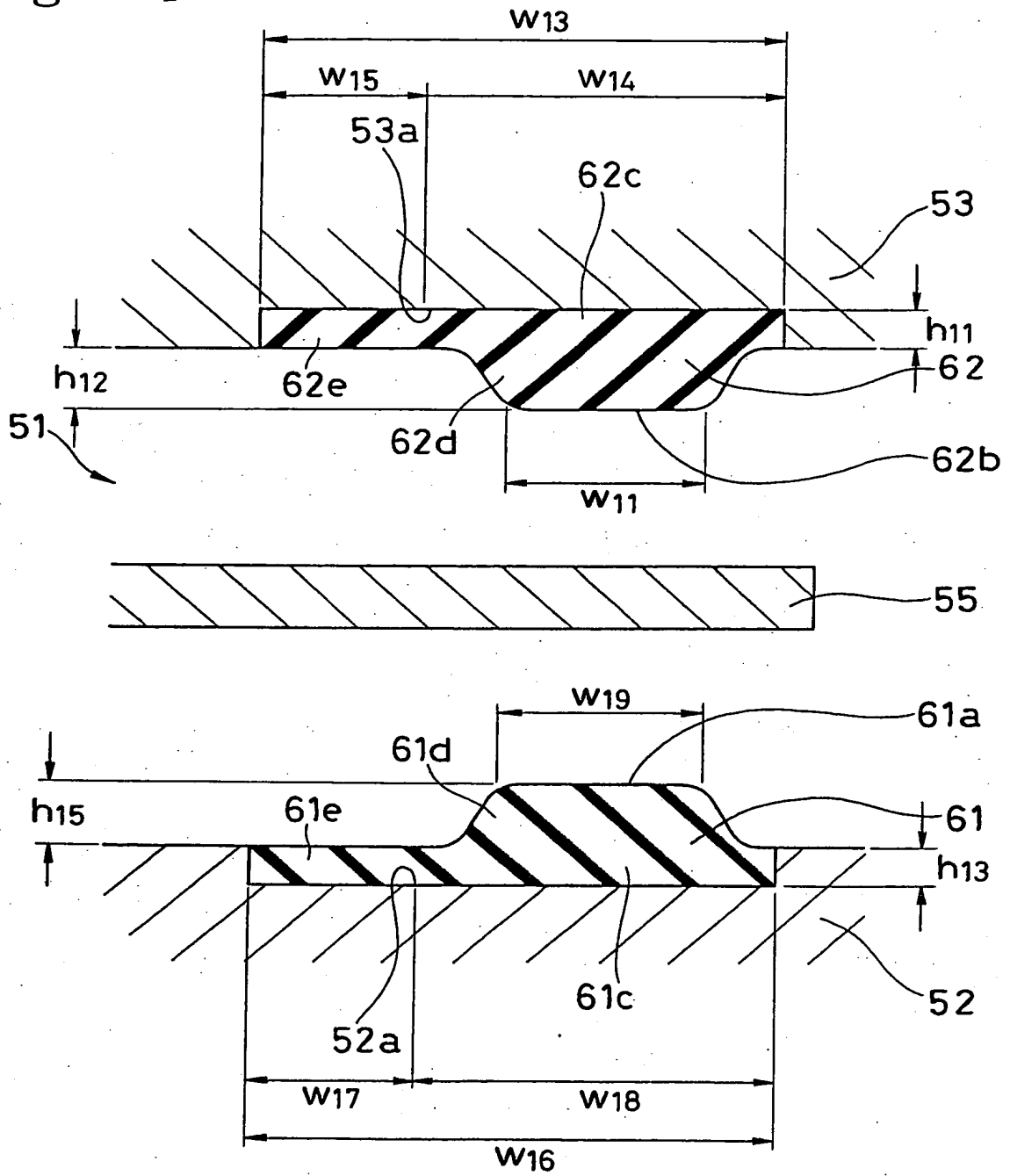
【Fig. 10】



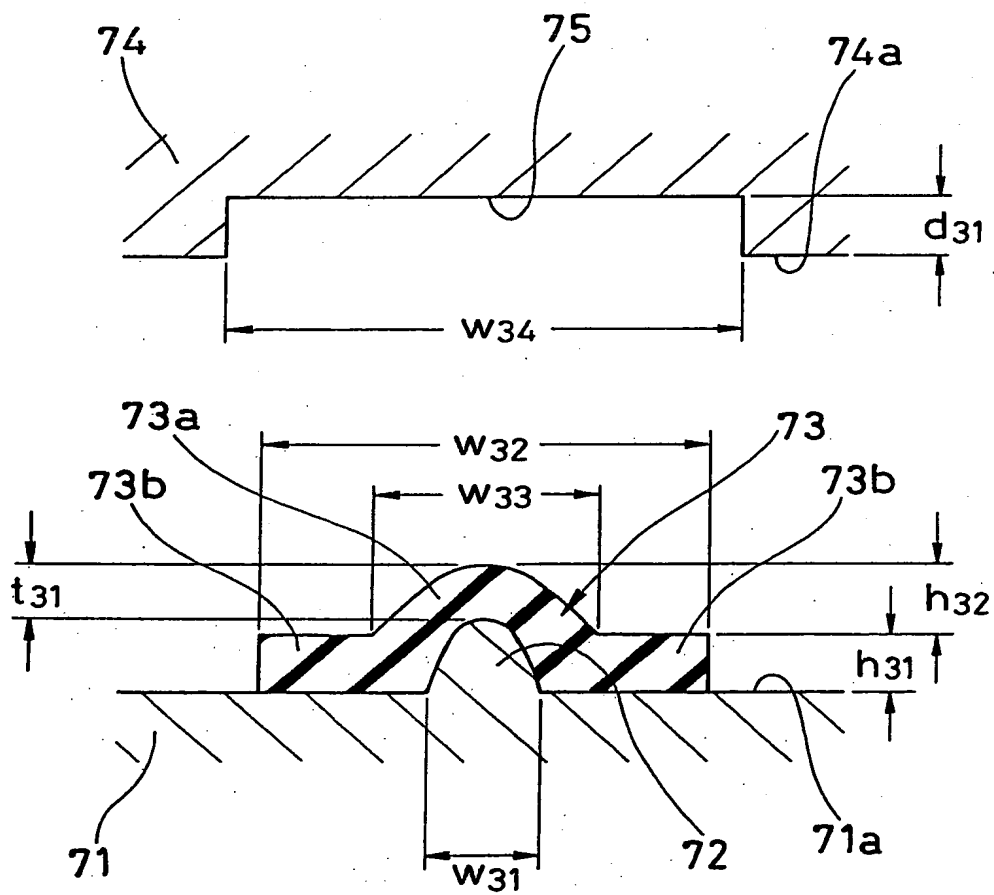
【Fig. 11】



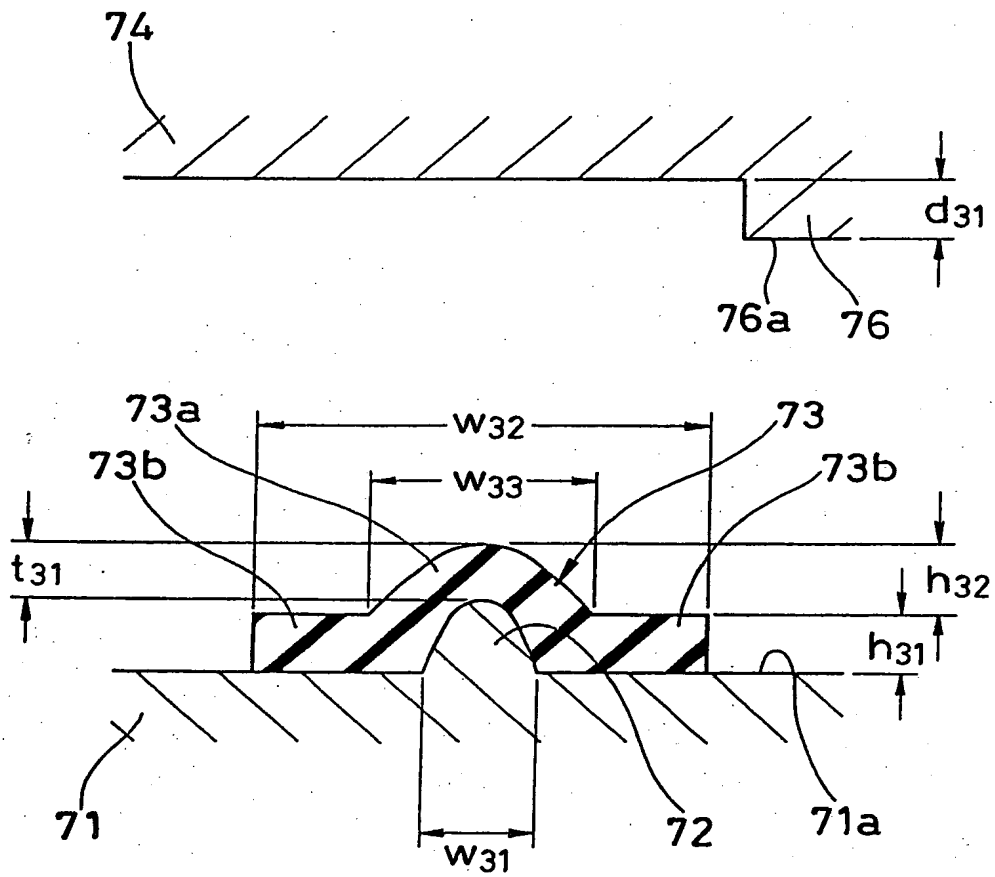
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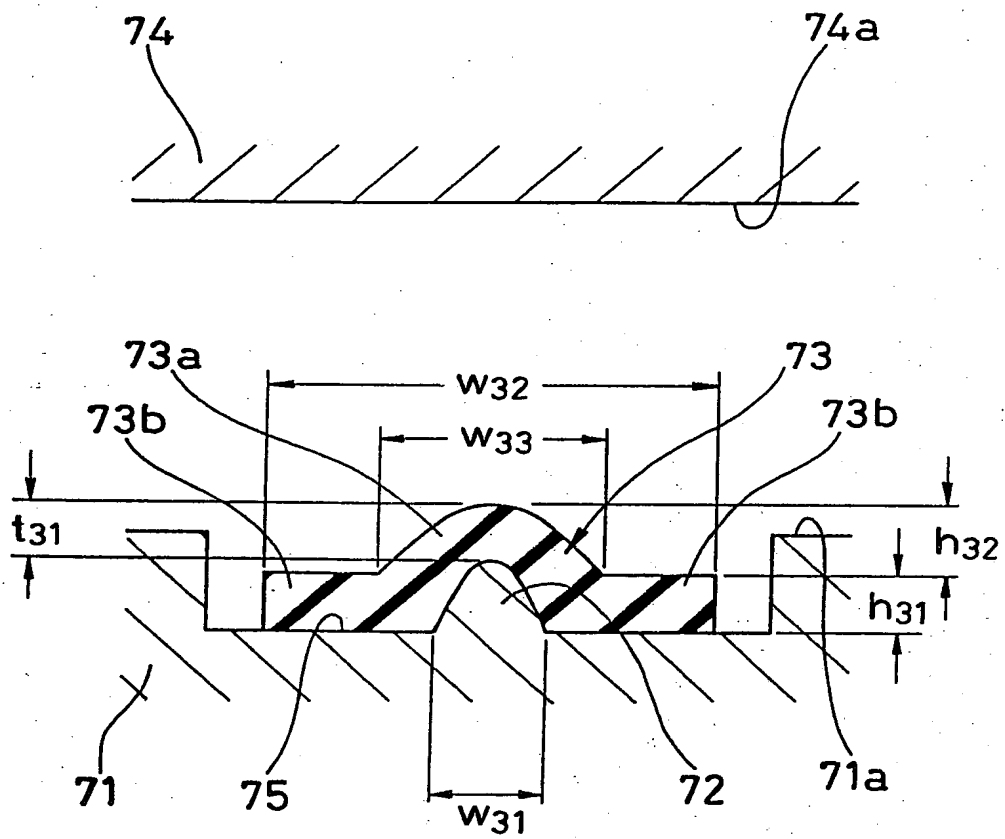
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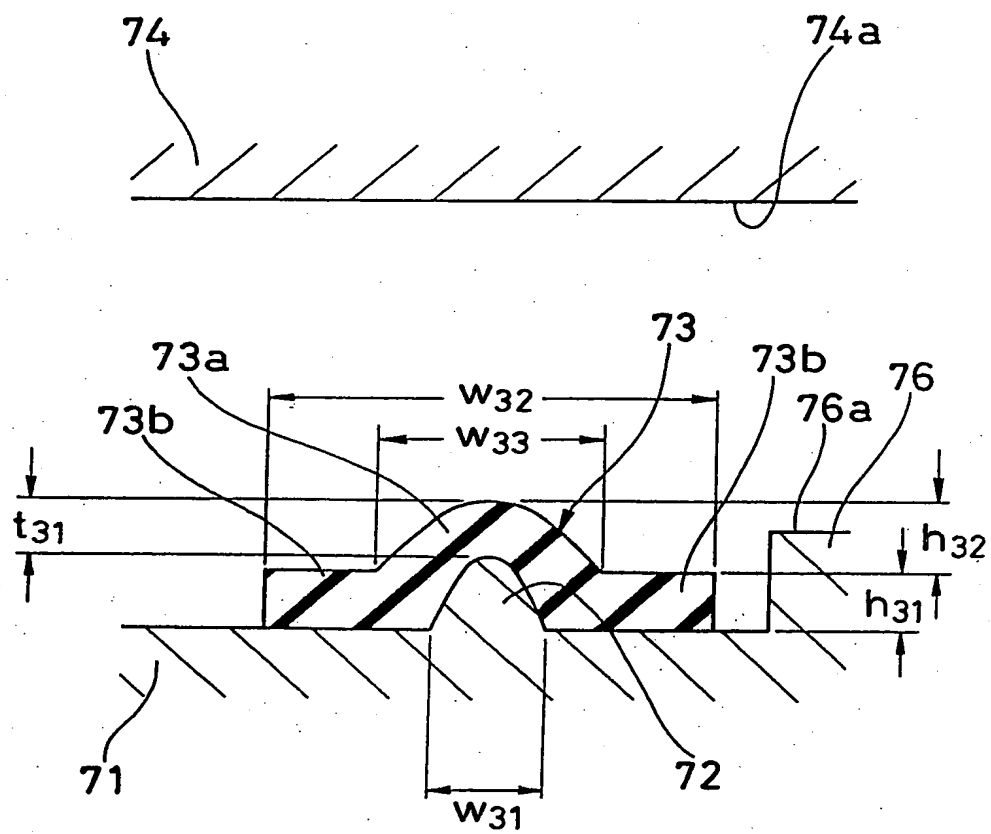
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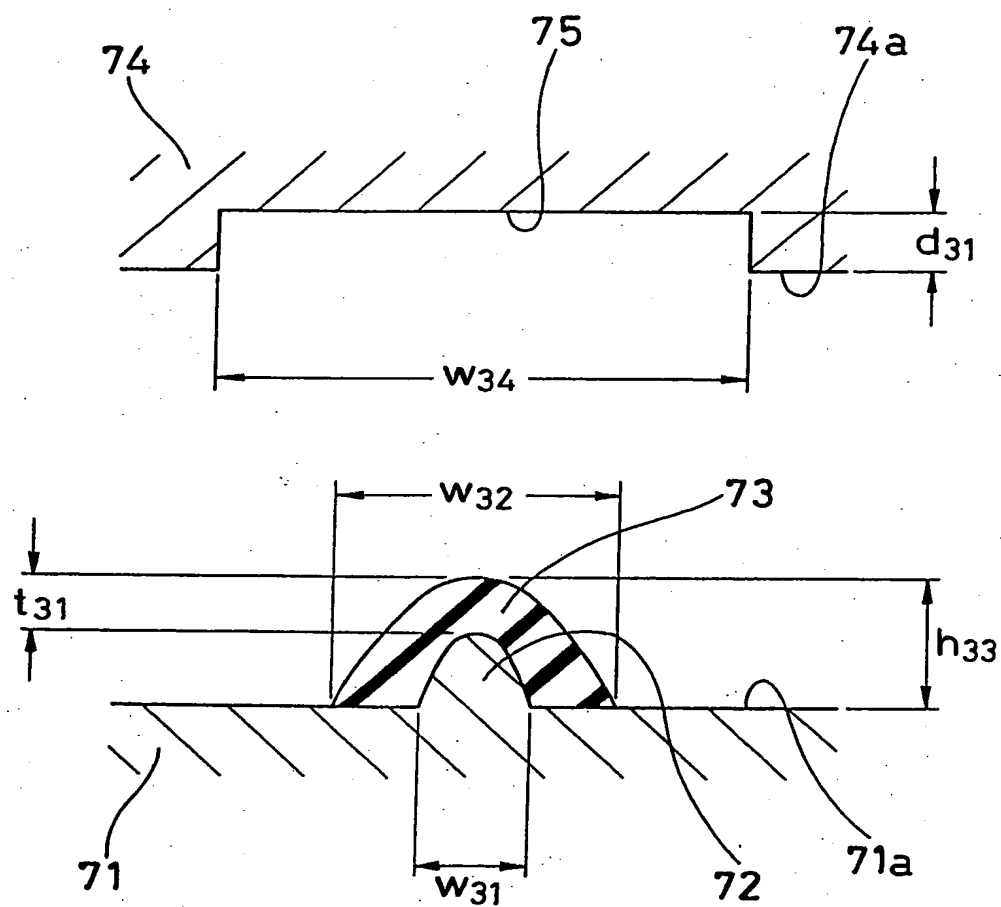
【Fig. 15】



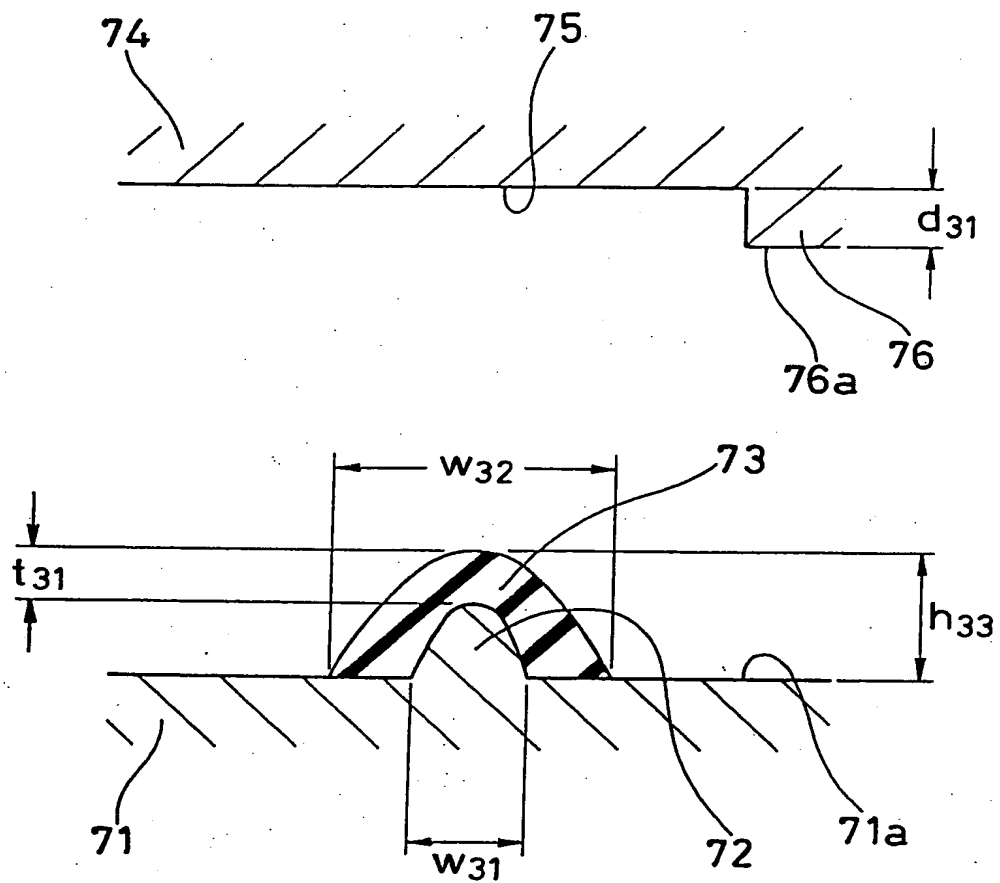
【Fig. 16】



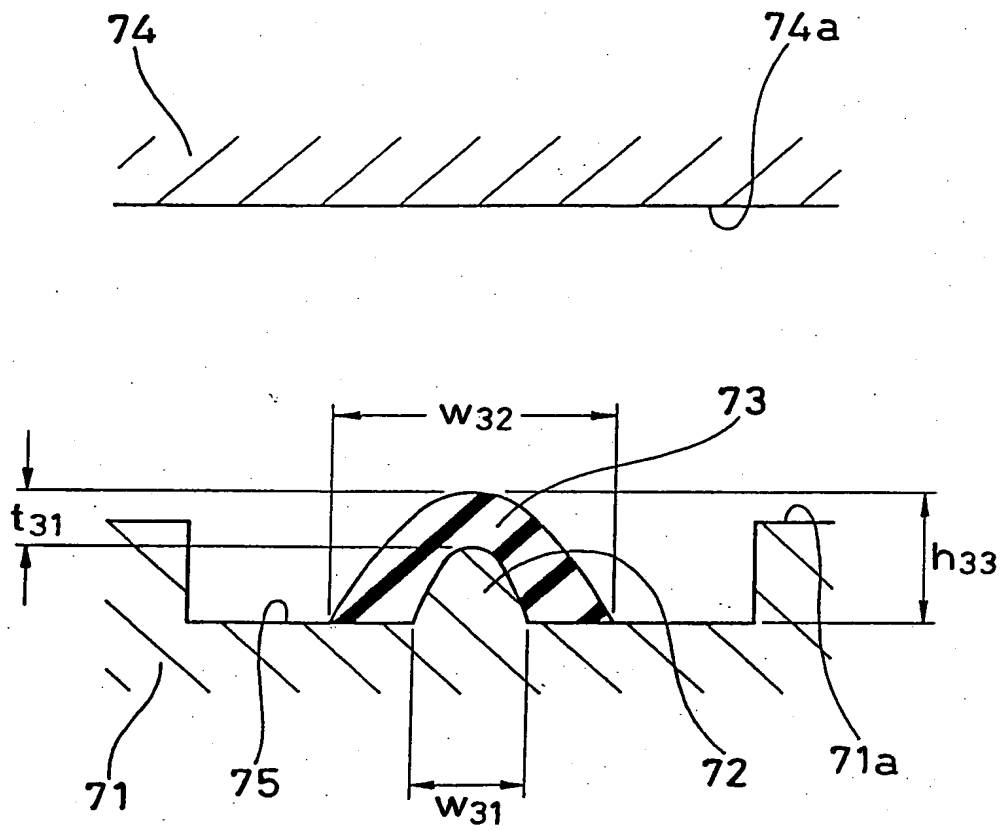
【Fig. 17】



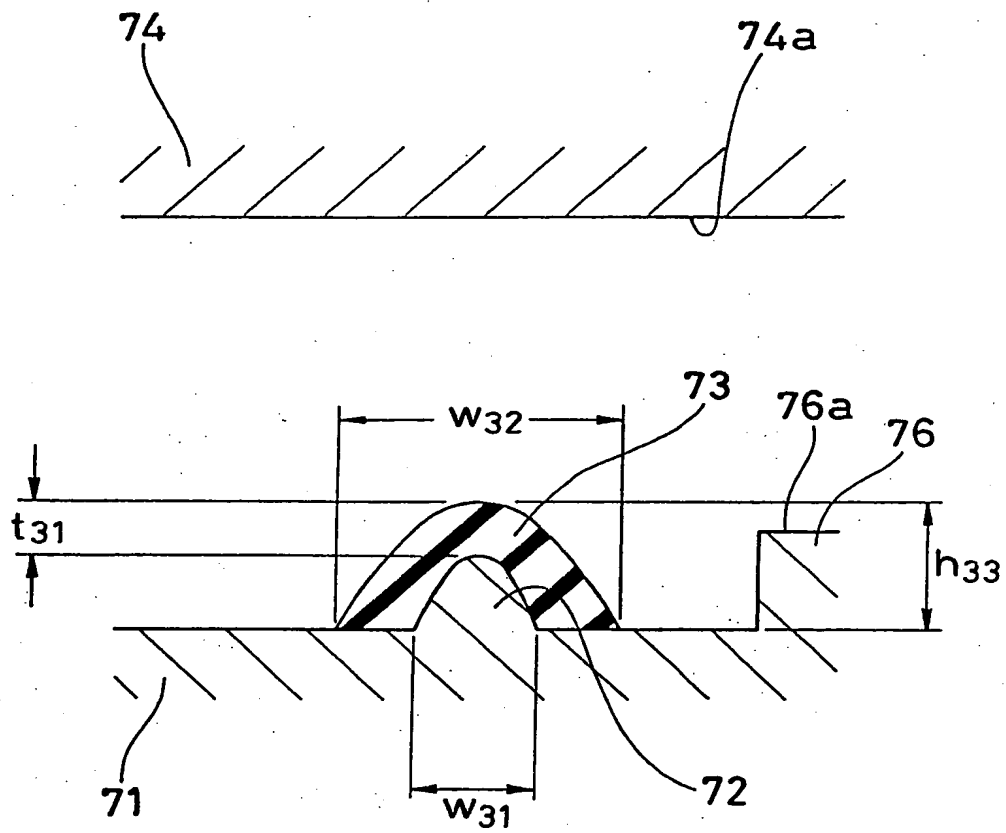
【Fig. 18】



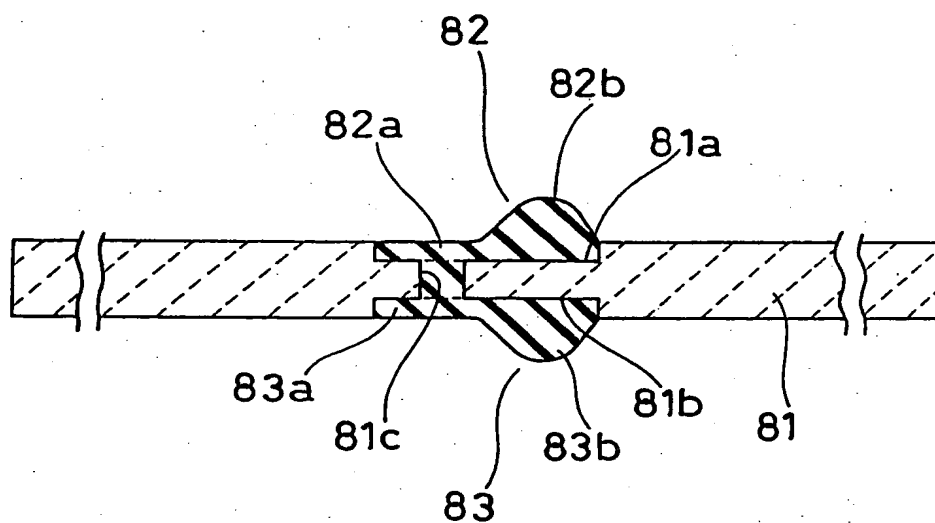
【Fig. 19】



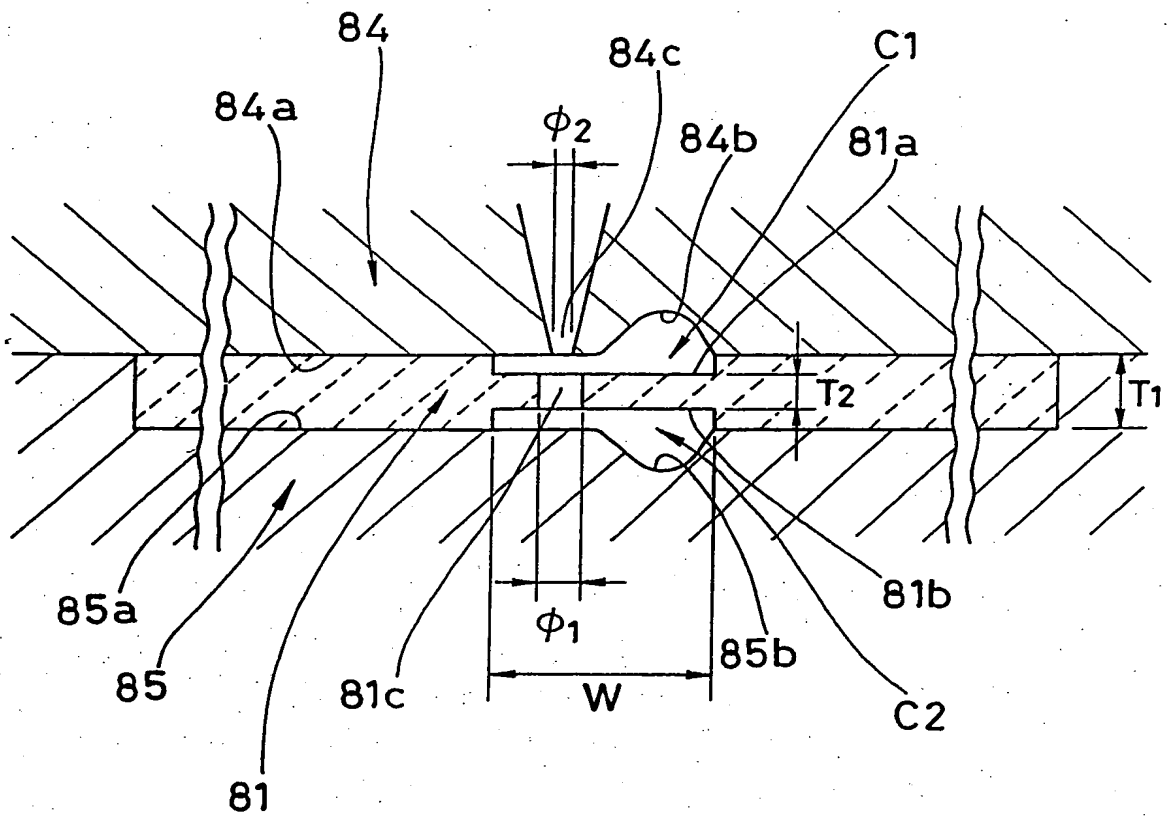
【Fig. 20】



【Fig. 21】



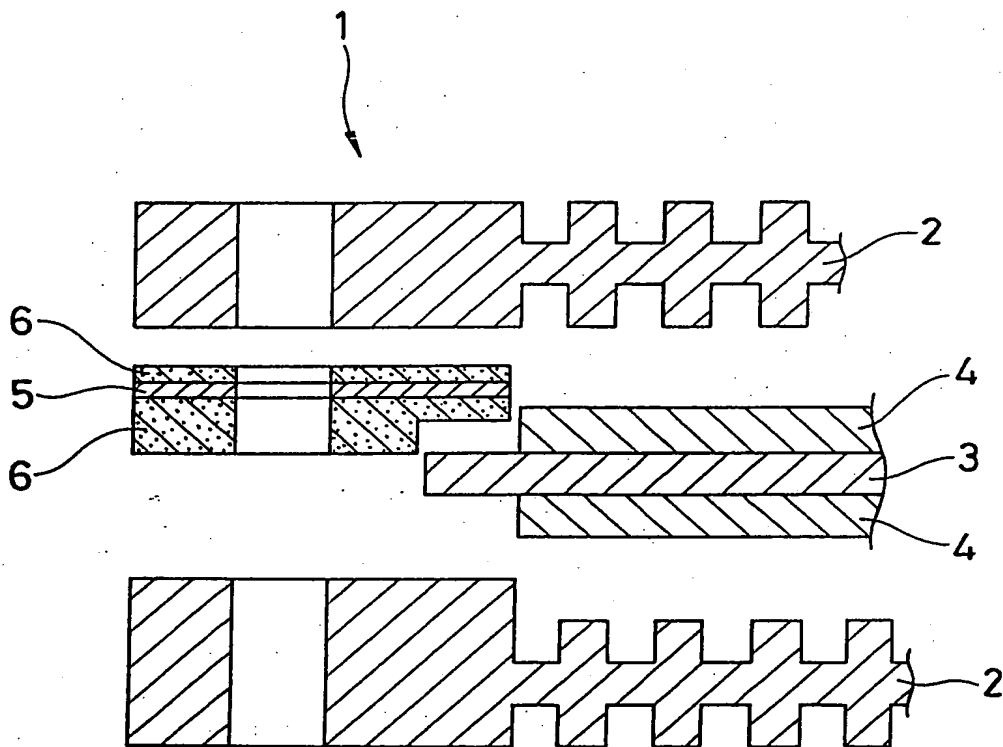
【Fig. 22】



【Fig. 23】

	Injection molding pressure	Mold clamping pressure	Injection molding pressure	Mold clamping pressure
	30 MPa	1.8 ton	10 MPa	1.8 ton
Comparative embodiment	Crack generated		Good result	
Embodiment	Good result		Good result	

【Fig. 24】



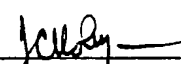
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED / ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		ATTORNEY'S DOCKET NUMBER P67506US0
		US APPLICATION NO. (If known, see 37 CFR 1.5)
INTERNATIONAL APPLICATION NO. PCT/JP00/03853	INTERNATIONAL FILING DATE 14 June 2000	PRIORITY DATE CLAIMED 13 July 1999
TITLE OF INVENTION GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME		
APPLICANT(S) FOR DO/EO/US Osamu NAGAI, Shigeo WAKAMATSU and Yuichi KUROKI		

Applicant herein submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information.

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for Internatl. Preliminary Examination was made by the 19th month from earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☒ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☒ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
10. ☐ A translation of the annexes to the Internatl. Preliminary Examination report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern other document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☒ An assignment document for recording. A separate cover sheet compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A **FIRST** preliminary amendment.
☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
14. ☐ A substitute specification.
15. ☐ A change of power of attorney and/or address letter.
16. ☒ Other items or information:
 - International Search Report – JPO
 - PCT/IB/304 Form
 - PCT/IB/346 Form
 - First Page of Publication
 - International Preliminary Examination Report

US APPLICATION NO. (If known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO. PCT/JP00/03853		ATTORNEY'S DOCKET NUMBER P67506US0	
17. <input checked="" type="checkbox"/> The following fees are submitted: Basic National Fee (37 CFR 1.492(a)(1)-(5)): Internatl. prelim. examination fee paid to USPTO (37 CFR 1.492 (a) (1)) .. \$710.00 No international preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (2)) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) .. \$740.00 Neither international preliminary examination fee (37 CFR 1.492 (a) (3)) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO) \$1040.00 International preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (4)) and all claims satisfied provisions of PCT Article 33(2)-(4) \$100.00 Search Report prepared by the EPO or JPO (37 CFR 1.492 (a) (5)) \$890.00 <div style="text-align: right;">ENTER APPROPRIATE BASIC FEE AMOUNT =</div>				CALCULATIONS \$ 890.00	
Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				\$	
Claims	Number Filed	Number Extra	Rate		
Total Claims	24 - 20 =	-4-	x \$18.00	\$ 72.00	
Independent Claims	8 - 3 =	-5-	x \$84.00	\$ 420.00	
Multiple Dependent Claim(s) (if applicable)			+ \$280.00	\$	
TOTAL OF ABOVE CALCULATIONS =				\$ 1382.00	
Reduction by 1/2 for filing by small entity, if applicable. Verified Small Entity statement must also be filed. (Note 37 CFR 1.9, 1.27, 1.28).				\$	
SUBTOTAL =				\$ 1382.00	
Processing fee of \$130 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f))				\$	
TOTAL NATIONAL FEE =				\$ 1382.00	
Fee of \$40.00 for recording the enclosed assignment (37 CFR 1.21(h)). Assignment must be accompanied by appropriate cover sheet (37 CFR 3.28, 3.31).				\$	
TOTAL FEES ENCLOSED =				\$ 1422.00	
				Amt. to be refunded:	\$
				Amt. charged:	\$
<p>a. <input checked="" type="checkbox"/> A check in the amount of \$ <u>1422.00</u> to cover the above fees is enclosed.</p> <p>b. <input type="checkbox"/> Please charge my Deposit Account No. <u>06-1358</u> in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.</p> <p>c. <input checked="" type="checkbox"/> The Commissioner is hereby authorized to charge my account any additional fees set forth in §1.492 during the pendency of this application, or credit any overpayment to Deposit Account No. <u>06-1358</u>. A duplicate copy of this sheet is enclosed.</p> <p style="text-align: center; margin-top: 20px;">SEND ALL CORRESPONDENCE TO:</p> <div style="display: flex; justify-content: space-between; align-items: flex-start;"> <div style="width: 60%;"> <p>JACOBSON HOLMAN PLLC 400 7th Street, N.W., Suite 600 Washington, DC 20004 202-638-6666 CUSTOMER NUMBER: 00136</p> </div> <div style="width: 35%; text-align: right;"> <p>By <u></u> John C. Holman Reg. No. 22,769</p> </div> </div>					

DATE	01-10-07	IN PAYMENT FOR		AMOUNT
FILING FEE	1382.00	ASSIGNMENT FEE	40.00	1422.00
ISSUE FEE		APPEAL FEE		
AMENDMENT		MISCELLANEOUS		
APPLICANT			UNION PATENT SERVICE CTR., INC.	
SER. NO.	12407	MARK	JRC	
OUR FILE NO. P67506US0		WRITER		
CHARGE TO				

P.O. 56390

**TRANSMITTAL LETTER TO THE UNITED STATES
DESIGNATED / ELECTED OFFICE (DO/EO/US)
CONCERNING A FILING UNDER 35 U.S.C. 371**

ATTORNEY'S DOCKET NUMBER

P67506US0

US APPLICATION NO. (If known, see 37 CFR 1.5)

INTERNATIONAL APPLICATION NO.

PCT/JP00/03853

INTERNATIONAL FILING DATE

14 June 2000

PRIORITY DATE CLAIMED

13 July 1999

TITLE OF INVENTION

GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME

APPLICANT(S) FOR DO/EO/US

Osamu NAGAI, Shigeo WAKAMATSU and Yuichi KUROKI

Applicant herein submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information.

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2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
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5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
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 - a. ☒ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☒ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
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15. ☐ A change of power of attorney and/or address letter.
16. ☒ Other items or information:

International Search Report – JPO

PCT/IB/304 Form

PCT/IB/346 Form

First Page of Publication

International Preliminary Examination Report

US APPLICATION NO. (If known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO. PCT/JP00/03853		ATTORNEY'S DOCKET NUMBER P67506US0	
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<p>17. <input checked="" type="checkbox"/> The following fees are submitted:</p> <p>Basic National Fee (37 CFR 1.492(a)(1)-(5)):</p> <p>Internatl. prelim. examination fee paid to USPTO (37 CFR 1.492 (a) (1)) .. \$710.00</p> <p>No international preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (2)) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) .. \$740.00</p> <p>Neither international preliminary examination fee (37 CFR 1.492 (a) (3)) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO) \$1040.00</p> <p>International preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (4)) and all claims satisfied provisions of PCT Article 33(2)-(4) \$100.00</p> <p>Search Report prepared by the EPO or JPO (37 CFR 1.492 (a) (5)) \$890.00</p> <p style="text-align: center;">ENTER APPROPRIATE BASIC FEE AMOUNT =</p>				CALCULATIONS		PTO USE ONLY	
				\$	890.00		

Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				\$	
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Claims	Number Filed	Number Extra	Rate		
Total Claims	24 - 20 =	-4-	x \$18.00	\$	72.00
Independent Claims	8 - 3 =	-5-	x \$84.00	\$	420.00
Multiple Dependent Claim(s) (if applicable)			+ \$280.00	\$	
TOTAL OF ABOVE CALCULATIONS =				\$	1382.00

Reduction by 1/2 for filing by small entity, if applicable. Verified Small Entity statement must also be filed. (Note 37 CFR 1.9, 1.27, 1.28).				\$	
SUBTOTAL =				\$	1382.00

Processing fee of \$130 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f))				\$	
TOTAL NATIONAL FEE =				\$	1382.00

Fee of \$40.00 for recording the enclosed assignment (37 CFR 1.21(h)). Assignment must be accompanied by appropriate cover sheet (37 CFR 3.28, 3.31).				\$	
TOTAL FEES ENCLOSED =				\$	1422.00

				Amt. to be refunded:	\$
				Amt. charged:	\$

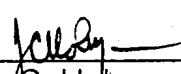
a. ☒ A check in the amount of \$ 1422.00 to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. 06-1358 in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge my account any additional fees set forth in §1.492 during the pendency of this application, or credit any overpayment to Deposit Account No. 06-1358. A duplicate copy of this sheet is enclosed.

SEND ALL CORRESPONDENCE TO:

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By 
 John C. Holman
 Reg. No. 22,769

JPH&S 3/95

30 October, 2000

World Intellectual Property Organization
PCT Division
34 Chemin des Colombettes
1211 Geneva 20
Switzerland

Amendment of the claims under Article 19(1) (Rule 46)

International Application No.: PCT/JP00/03853

International Filing Date: 14 June, 2000

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Applicant's or Agent's File reference: PCT-16069

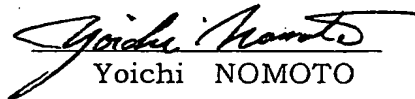
Dear sir

The Applicant, who received the International Search Report relating to the above identified International Application transmitted on 14 June 2000, hereby files amendment under Article 19(1) as in the attached sheets.

Claims 23 and 24 are added by this amendment.

The Applicant also files as attached herewith a brief statement explaining the amendment.

Very truly yours,


Yoichi NOMOTO

Attachment:

- | | |
|-----------------------------------|----------|
| (1) Amendment under Article 19(1) | 4 sheets |
| (2) Brief Statement | 1 sheet |

請求の範囲

1. 平面プレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。

2. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

平面プレートが、集電極、イオン交換膜または膜固定反応電極であることを特徴とする燃料電池用ガスケット。

3. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

液状ゴム硬化物が、硬さ(JIS A) 60以下であることを特徴する燃料電池用ガスケット。

4. 請求の範囲第3項に記載した燃料電池用ガスケットにおいて、

液状ゴム硬化物の硬さ(JIS A) が好ましくは5~50、より好ましくは10~40であることを特徴する燃料電池用ガスケット。

5. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

液状ゴムの粘度(Pa・s (25℃)) が30~10,000、好ましくは30~2,000であることを特徴とする燃料電池用ガスケット。

6. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

液状ゴム硬化物よりなるガスケットリップの断面形状が台形または山形であることを特徴とする燃料電池用ガスケット。

7. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

液状ゴム硬化物よりなるガスケットリップの断面形状が、断面台形の部分または断面山形の部分を備えていることを特徴とする燃料電池用ガスケット。

8. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップのシール部は断面円弧状であることを特徴とする燃料電池用ガスケット。

9. 請求の範囲第8項に記載した燃料電池用ガスケットにおいて、

シール部は高さが略0.2~1.5mmであることを特徴とする燃料電池用ガ

スケット。

10. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップのシール部は断面山形、凸形ないし三角形状であることを特徴とする燃料電池用ガスケット。

11. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部は高さが略0.3～1.5mmであることを特徴とする燃料電池用ガスケット。

12. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部の先端部は断面円弧状であることを特徴とする燃料電池用ガスケット。

13. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップの断面形状が互いに異なるように形成され、一方の前記ガスケットリップに、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

14. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

15. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、イオン交換膜を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記イオン交換膜に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

16. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を覆うよ

うにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

17. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布し、その領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

18. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布せずにその領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

19. 請求の範囲第1項ないし第18項の何れかに記載した燃料電池用ガスケットの成形方法において、

射出前に上下金型の間に隙間を設けて真空引きし、その後、型締めしてガスケットリップを射出成形することを特徴とする燃料電池用ガスケットの成形方法。

20. 請求の範囲第19項に記載した燃料電池用ガスケットの成形方法において

平面プレートの両面または前記両面に施された溝部の底面に開口する貫通穴を設け、前記貫通穴を介して前記両面または両溝部に同時にガスケットリップを一体成形することを特徴とする燃料電池用ガスケットの成形方法。

21. 基板の両面に互いに対応する一对の溝部を設け、前記一对の溝部を連通するように前記基板に連通孔を設け、前記一对の溝部および連通孔にエラストマーを充填するとともにこのエラストマーに凸状のシールリップを設け、前記連通孔を前記溝部の幅方向の一方に偏った位置に配置するとともに前記凸状のシールリップを反対側に偏った位置に配置したことを特徴とする燃料電池用ガスケット。

22. 基板の両面にエラストマーからなるシールリップを一体に備えるガスケットの製造において、

前記基板に、その両面に衝合される金型との間に形成されるシールリップ成形用キャビティの間を連通する連通孔を開設し、

前記連通孔は前記両シールリップ成形用キャビティの一方へ開口したゲートと対応する位置にあってこのゲートよりも大径に形成され、

前記ゲートから供給される成形材料を前記連通孔を介して前記両シールリップ成形用キャビティへ充填することを特徴とするガスケットの成形方法。

23. (追加) カーボンプレート表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。

24. (追加) グラファイトプレート表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。

条約第 19 条（1）に基づく説明書

新たに追加する請求の範囲第 23 項は、カーボンプレート¹の表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、本件国際調査報告で引用された何れの引例にも記載されていないものである。

また、同じく新たに追加する請求の範囲第 24 項は、グラファイトプレート²の表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、やはり本件国際調査報告で引用された何れの引例にも記載されていないものである。

(2)

****HAND CARRY** TO PCT WINDOW, CRYSTAL PLAZA II, 8TH FLOOR**

Att'y Docket: P67506US0
Serial No.: New U.S. National Phase Application
Applicant: NAGAI et al
Filing Date: January 10, 2002

Today's Date: January 10, 2002

The following has been received in the U.S. Patent & Trademark Office on the date stamped hereon:

- ☒ Preliminary Amendment
- ☒ International Search Report (210)
- ☒ PCT/IB/304/346 Form(s)
- ☒ First Page of Publ.
- ☒ Article 19 Amendment and Statement in Japanese
- ☒ IPER (409)
- ☒ 78 pg. Specif. with 24 claims, Abstract, and Article 19 translation attached thereto
- ☒ 24 Sheets of Drawings
- ☒ Declaration and Power of Attorney (2 pages)
- ☒ Assignment document and cover sheet

10/030076

98 Rec'd PCT/PTO 10 JAN 2002

Check for \$ 1422.00 Check No. 56390

DUE DATE: January 13, 2002

JACOBSON HOLMAN PLLC
400 SEVENTH STREET, NW
WASHINGTON, DC 20004

JRC

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JACOBSON HOLMAN PLLC
400 SEVENTH STREET, NW
WASHINGTON, DC 20004

10/030076

EARLY SERIAL NO. _____

JRC



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IMPORTANT

**FACSIMILE COVER LETTER
NO MAIL BACK-UP**

FAX TO THE FOLLOWING NUMBER: 703-872-9306

From: John C. Holman

Date: June 10, 2004

To: Examiner Hoa Van LE

U.S. Patent and Trademark Office, Art Unit 1752

Name

Organization

Re: S/N 10/030,076 --Resend Missing Claims 23-24, Abstract and supporting documents

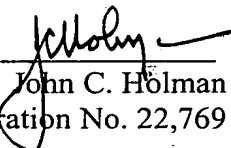
Our Ref.: P67506US0

TOTAL NUMBER OF PAGES, INCLUDING COVER LETTER: 16

Dear Mr. Le:

According to previous telephone conversation, attached please find the copies of the specification with pages including missing Claims 23-24 and Abstract (pages 75-78), transmittal letter, check, postcard, Article 19 amendment letter. As you indicated, please consider Claims 23-24 and issue new non-final Office Action with statutory period of reply starting from the mailing date of the new Office Action. The Commissioner is also authorized to charge payment of any additional fees associated with this communication or credit any overpayment to Deposit Account No. 06-1358. A duplicate copy of this sheet is attached.

The undersigned hereby certifies that the attached documents were sent via facsimile to the U.S. Patent and Trademark Office on the noted date.

By 
John C. Holman
Registration No. 22,769

This 10 day of June, 2004

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Harvey B. Jacobson, Jr. John Clarke Holman Simor L. Moskowitz Allen S. Meiser Michael R. Slobasky Marsha G. Gentner Jonathan L. Scherer
Irwin M. Aisenberg George W. Lewis William E. Player Yoon S. Ham Philip L. O'Neill
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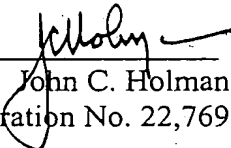
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Irwin M. Aisenberg George W. Lewis William E. Player Yoon S. Ham Philip L. O'Neill
Linda J. Shapiro Leesa N. Weiss Joseph G. Contrera Suzin C. Bailey* Matthew J. Cuccias Jiwen Chen* Robert S. Pierce*
Of Counsel: Marvin R. Stern Nathaniel A. Humphries

ABSTRACT OF THE DISCLOSURE

In a gasket used for a fuel battery, in order to solve problems with respect to making a seal portion thin, improving an assembling property, preventing a position shift, making a surface pressure low, making the surface pressure uniform, and the like, a gasket lip made of a liquid rubber hardened material is integrally formed on a surface of a flat plate made of a carbon, a graphite, a conductive resin such as a conductive phenol resin or the like, an ion exchange resin, or a metal such as a stainless steel, a magnesium alloy or the like, or on a groove portion applied to the surface.

23. (Added) A gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a carbon plate or a groove portion applied to said surface.

24. (Added) A gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a graphite plate or a groove portion applied to said surface.

Description on the basis of Treaty 19(1)

Newly added claim 23 relates to a gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a carbon plate or a groove portion applied to the surface, and is described in none of the references cited in the International Search Report with respect to the present case.

Further, newly added claim 24 relates to a gasket for a fuel battery characterized in that a gasket lip made of a liquid rubber hardened material is integrally formed in a surface of a graphite plate or a groove portion applied to the surface, and is also described in none of the references cited in the International Search Report with respect to the present case.

Fig. 3

CLAMP MOLD AT LOW PRESSURE

IS MOLD CLAMPING TEMPORARILY STOPPING POSITION ?

S101 STOP MOLD CLAMPING

S102 MOVE FORWARD NOZZLE

IS NOZZLE TOUCH COMPLETED ?

S103 TURN ON VACUUM PUMP

IS SET VACUUM ?

IS SET EVACUATING TIME ?

S104 CLAMP MOLD AT HIGH PRESSURE

OPEN SHUT-OFF VALVE

S105 INJECT

Fig. 23

MOLDING PRESSURE

MOLD CLAMPING FORCE

MOLDING PRESSURE

MOLD CLAMPING FORCE

COMPARATIVE EMBODIMENT

CRACK GENERATION

GOOD

EMBODIMENT

GOOD

GOOD

30 October, 2000

World Intellectual Property Organization
PCT Division
34 Chemin des Colombettes
1211 Geneva 20
Switzerland

Amendment of the claims under Article 19(1) (Rule 46)

International Application No.: PCT/JP00/03853

International Filing Date: 14 June, 2000

Applicant: NOK CORPORATION et al.

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telephone number(national): 03-3506-7879 (international):813-3506-7879

Applicant's or Agent's File reference: PCT-16069

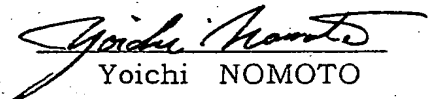
Dear sir

The Applicant, who received the International Search Report relating to the above identified International Application transmitted on 14 June 2000, hereby files amendment under Article 19(1) as in the attached sheets.

Claims 23 and 24 are added by this amendment.

The Applicant also files as attached herewith a brief statement explaining the amendment.

Very truly yours,


Yoichi NOMOTO

Attachment:

(1) Amendment under Article 19(1)	4 sheets
(2) Brief Statement	1 sheet

請求の範囲

1. 平面プレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。
2. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
平面プレートが、集電極、イオン交換膜または膜固定反応電極であることを特徴とする燃料電池用ガスケット。
3. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物が、硬さ（J I S A）60以下であることを特徴する燃料電池用ガスケット。
4. 請求の範囲第3項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物の硬さ（J I S A）が好ましくは5～50、より好ましくは10～40であることを特徴する燃料電池用ガスケット。
5. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴムの粘度（Pa・s（25℃））が30～10,000、好ましくは30～2,000であることを特徴とする燃料電池用ガスケット。
6. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物よりなるガスケットリップの断面形状が台形または山形であることを特徴とする燃料電池用ガスケット。
7. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
液状ゴム硬化物よりなるガスケットリップの断面形状が、断面台形の部分または断面山形の部分を備えていることを特徴とする燃料電池用ガスケット。
8. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、
ガスケットリップのシール部は断面円弧状であることを特徴とする燃料電池用ガスケット。
9. 請求の範囲第8項に記載した燃料電池用ガスケットにおいて、
シール部は高さが略0.2～1.5mmであることを特徴とする燃料電池用ガ

スケット。

10. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップのシール部は断面山形、凸形ないし三角形状であることを特徴とする燃料電池用ガスケット。

11. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部は高さが略0.3～1.5mmであることを特徴とする燃料電池用ガスケット。

12. 請求の範囲第10項に記載した燃料電池用ガスケットにおいて、

シール部の先端部は断面円弧状であることを特徴とする燃料電池用ガスケット。

13. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップの断面形状が互いに異なるように形成され、一方の前記ガスケットリップに、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

14. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、電解質膜部を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記電解質膜部に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

15. 電極の表面または前記表面に施された溝部に一体成形された液状ゴム硬化物よりなるガスケットリップを有し、イオン交換膜を挟み込むように配置される一対の前記ガスケットリップのうちの少なくとも一方に、前記イオン交換膜に接触する所定の幅を備えた平面部が形成されていることを特徴とする燃料電池用ガスケット。

16. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を覆うよ

うにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

17. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布し、その領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

18. 請求の範囲第1項に記載した燃料電池用ガスケットにおいて、

ガスケットリップラインに沿う突起を平面プレートに設け、前記突起を中心に接着剤を塗布せずにその領域を覆うようにガスケットリップを形成したことを特徴とする燃料電池用ガスケット。

19. 請求の範囲第1項ないし第18項の何れかに記載した燃料電池用ガスケットの成形方法において、

射出前に上下金型の間に隙間を設けて真空引きし、その後、型締めしてガスケットリップを射出成形することを特徴とする燃料電池用ガスケットの成形方法。

20. 請求の範囲第19項に記載した燃料電池用ガスケットの成形方法において、

平面プレートの両面または前記両面に施された溝部の底面に開口する貫通穴を設け、前記貫通穴を介して前記両面または両溝部に同時にガスケットリップを一体成形することを特徴とする燃料電池用ガスケットの成形方法。

21. 基板の両面に互いに対応する一对の溝部を設け、前記一对の溝部を連通するように前記基板に連通孔を設け、前記一对の溝部および連通孔にエラストマーを充填するとともにこのエラストマーに凸状のシールリップを設け、前記連通孔を前記溝部の幅方向の一方に偏った位置に配置するとともに前記凸状のシールリップを反対側に偏った位置に配置したことを特徴とする燃料電池用ガスケット。

22. 基板の両面にエラストマーからなるシールリップを一体に備えるガスケットの製造において、

前記基板に、その両面に衝合される金型との間に形成されるシールリップ成形用キャビティの間を連通する連通孔を開設し、

前記連通孔は前記両シールリップ成形用キャビティの一方へ開口したゲートと対応する位置にあってこのゲートよりも大径に形成され、

前記ゲートから供給される成形材料を前記連通孔を介して前記両シールリップ成形用キャビティへ充填することを特徴とするガスケットの成形方法。

23. (追加) カーボンプレート表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。

24. (追加) グラファイトプレート表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケット。

条約第 19 条 (1) に基づく説明書

新たに追加する請求の範囲第 23 項は、カーボンプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、本件国際調査報告で引用された何れの引例にも記載されていないものである。

また、同じく新たに追加する請求の範囲第 24 項は、グラファイトプレートの表面または前記表面に施された溝部に、液状ゴム硬化物よりなるガスケットリップを一体成形したことを特徴とする燃料電池用ガスケットであり、やはり本件国際調査報告で引用された何れの引例にも記載されていないものである。

TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED / ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		ATTORNEY'S DOCKET NUMBER P67506US0
		US APPLICATION NO. (If known, see 37 CFR 1.5)
INTERNATIONAL APPLICATION NO. PCT/JP00/03853	INTERNATIONAL FILING DATE 14 June 2000	PRIORITY DATE CLAIMED 13 July 1999
TITLE OF INVENTION GASKET FOR FUEL BATTERY AND METHOD OF FORMING THE SAME		
APPLICANT(S) FOR DO/EO/US Osamu NAGAI, Shigeo WAKAMATSU and Yuichi KUROKI		

Applicant herein submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information.

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☒ This express request to begin national examination procedures (35 U.S.C. 371(f)) at any time rather than delay examination until the expiration of the applicable time limit set in 35 U.S.C. 371(b) and PCT Articles 22 and 39(1).
4. ☒ A proper Demand for Internatl. Preliminary Examination was made by the 19th month from earliest claimed priority date.
5. ☒ A copy of the International Application as filed (35 U.S.C. 371(c)(2))
 - a. ☐ is transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ has been transmitted by the International Bureau.
 - c. ☐ is not required, as the application was filed in the United States Receiving Office (RO/US)
6. ☒ A translation of the International Application into English (35 U.S.C. 371(c)(2)).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))
 - a. ☒ are transmitted herewith (required only if not transmitted by the International Bureau).
 - b. ☒ have been transmitted by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☒ A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).
9. ☒ An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).
10. ☐ A translation of the annexes to the Internatl. Preliminary Examination report under PCT Article 36 (35 U.S.C. 371(c)(5)).

Items 11. to 16. below concern other document(s) or information included:

11. ☐ An Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☒ An assignment document for recording. A separate cover sheet compliance with 37 CFR 3.28 and 3.31 is included.
13. ☒ A **FIRST** preliminary amendment.
☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
14. ☐ A substitute specification.
15. ☐ A change of power of attorney and/or address letter.
16. ☒ Other items or information:

International Search Report – JPO
PCT/IB/304 Form
PCT/IB/346 Form
First Page of Publication
International Preliminary Examination Report

US APPLICATION NO. (if known, see 37 CFR 1.5)		INTERNATIONAL APPLICATION NO. PCT/JP00/03853		ATTORNEY'S DOCKET NUMBER P67506US0	
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17. ☒ The following fees are submitted:

Basic National Fee (37 CFR 1.492(a)(1)-(5)):

Internatl. prelim. examination fee paid to USPTO (37 CFR 1.492 (a) (1)) ... \$710.00

No international preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (2)) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) ... \$740.00

Neither international preliminary examination fee (37 CFR 1.492 (a) (3)) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO) **\$1040.00**

International preliminary examination fee paid to USPTO (37 CFR 1.492 (a) (4)) and all claims satisfied provisions of PCT Article 33(2)-(4) \$100.00

Search Report prepared by the EPO or JPO (37 CFR 1.492 (a) (5)) **\$890.00**

ENTER APPROPRIATE BASIC FEE AMOUNT =

Surcharge of \$130.00 for furnishing the oath or declaration later than
☐ 20 ☐ 30 months from the earliest claimed priority date (37 CFR 1.492(e)).

Claims	Number Filed	Number Extra	Rate		
Total Claims	24 - 20 =	-4-	x \$18.00	\$	72.00
Independent Claims	8 - 3 =	-5-	x \$84.00	\$	420.00
Multiple Dependent Claim(s) (if applicable)			+ \$280.00	\$	
TOTAL OF ABOVE CALCULATIONS =				\$	1382.00
Reduction by 1/2 for filing by small entity , if applicable. Verified Small Entity statement must also be filed. (Note 37 CFR 1.9, 1.27, 1.28).				\$	
SUBTOTAL =				\$	1382.00
Processing fee of \$130 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492(f))				\$	
TOTAL NATIONAL FEE =				\$	1382.00
Fee of \$40.00 for recording the enclosed assignment (37 CFR 1.21(h)). Assignment must be accompanied by appropriate cover sheet (37 CFR 3.28, 3.31).				\$	
TOTAL FEES ENCLOSED =				\$	1422.00
				Amt. to be refunded:	\$
				Amt. charged:	\$

CALCULATIONS

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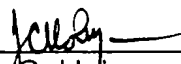
a. ☒ A check in the amount of \$ 1422.00 to cover the above fees is enclosed.

b. ☐ Please charge my Deposit Account No. 06-1358 in the amount of \$ _____ to cover the above fees. A duplicate copy of this sheet is enclosed.

c. ☒ The Commissioner is hereby authorized to charge my account any additional fees set forth in §1.492 during the pendency of this application, or credit any overpayment to Deposit Account No. 06-1358. A duplicate copy of this sheet is enclosed.

SEND ALL CORRESPONDENCE TO:

JACOBSON HOLMAN PLLC
 400 7th Street, N.W., Suite 600
 Washington, DC 20004
 202-638-6666
CUSTOMER NUMBER: 00136

By 
John C. Holman
 Reg. No. 22,769

JPH&S 3/95

****HAND CARRY** TO PCT WINDOW, CRYSTAL PLAZA II, 8TH FLOOR**

Att'y Docket: P67506US0

Today's Date: January 10, 2002

Serial No.: New U.S. National Phase Application

Applicant: NAGAI et al

Filing Date: January 10, 2002

The following has been received in the U.S. Patent & Trademark Office on the date stamped hereon

- ☒ Preliminary Amendment
- ☒ International Search Report (210)
- ☒ PCT/IB/304/346 Form(s)
- ☒ First Page of Publ.
- ☒ Article 19 Amendment and Statement in Japanese
- ☒ IPER (409)
- ☒ 78 pg. Specif. with 24 claims, Abstract, and Article 19 translation attached thereto
- ☒ 24 Sheets of Drawings
- ☒ Declaration and Power of Attorney (2 pages)
- ☒ Assignment document and cover sheet

98 Rec'd PCT/PTO 10 JAN 2002

Check for \$ 1422.00 Check No. 56390

DUE DATE: January 13, 2002

JACOBSON HOLMAN PLLC
400 SEVENTH STREET NW
WASHINGTON, DC 20004

10/030076

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DATE	IN PAYMENT FOR	AMOUNT
01-10-02	<div>1382.00</div> <div>40.00</div> <div>FILING FEE</div> <div>ISSUE FEE</div> <div>AMENDMENT</div> <div>APPLICANT</div> <div>SER. No. 12407</div> <div>Our File No. P-67506U\$0</div> <div>CHARGE TO</div> <div>ASSIGNMENT FEE</div> <div>APPEAL FEE</div> <div>MISCELLANEOUS</div> <div>UNION PATENT SERVICE CIR. INC.</div> <div>MARK JRC</div> <div>WRITER</div>	

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IMPORTANT

FACSIMILE COVER LETTER NO MAIL BACK-UP *****

FAX TO THE FOLLOWING NUMBER: 703-872-9306

From: John C. Holman

Date: June 10, 2004

To: Examiner Hoa Van LE

U.S. Patent and Trademark Office, Art Unit 1752

Name

Organization

Re: S/N 10/030,076 - Resend Missing Claims 23-24, Abstract and supporting documents

Our Ref: P67506USQ

TOTAL NUMBER OF PAGES, INCLUDING COVER LETTER: 16

Dear Mr. Le:

According to previous telephone conversation, attached please find the copies of the specification with pages including missing Claims 23-24 and Abstract (pages 75-78), transmittal letter, check, postcard, Article 19 amendment letter. As you indicated, please consider Claims 23-24 and issue new non-final Office Action with statutory period of reply starting from the mailing date of the new Office Action. The Commissioner is also authorized to charge payment of any additional fees associated with this communication or credit any overpayment to Deposit Account No. 06-1358. A duplicate copy of this sheet is attached.

The undersigned hereby certifies that the attached documents were sent via facsimile to the U.S. Patent and Trademark Office on the noted date.

By John C. Holman
John C. Holman
Registration No. 22,769

This 10 day of June, 2004

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PAGE 1/16 * RCVD AT 6/10/2004 2:10:31 PM [Eastern Daylight Time] * SVR:USPTO-EFAX-111 * DNS:8729306 * CSID:202 393 5350 * DURATION (mm:ss)04:40, New York, N.Y.